FIG. 1

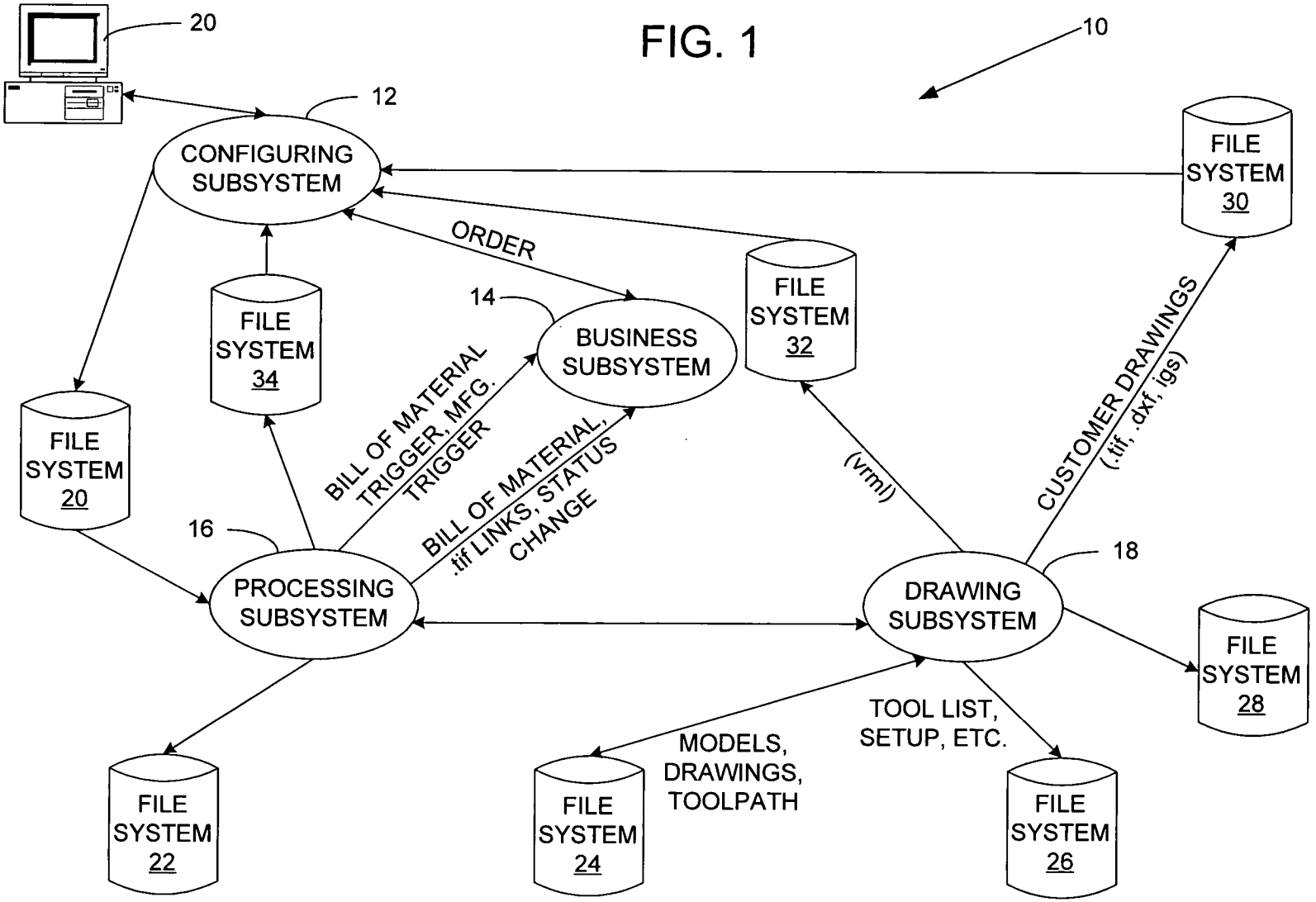
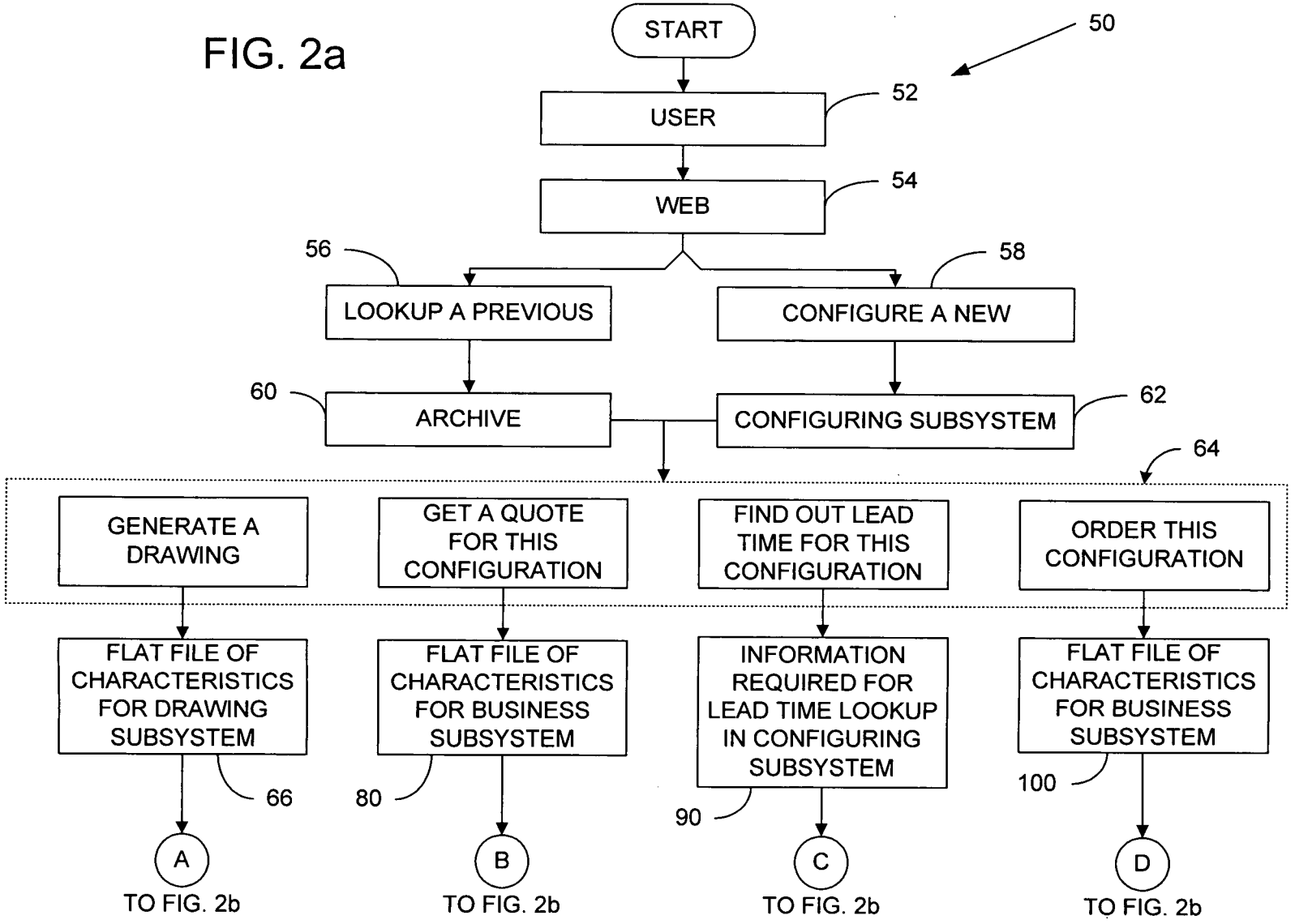

20
10
12
CONFIGURING SUBSYSTEM
FILE SYSTEM 30
ORDER
FILE SYSTEM 34
14
BUSINESS SUBSYSTEM
FILE SYSTEM 32
FILE SYSTEM 20
BILL OF MATERIAL TRIGGER, MFG. TRIGGER
BILL OF MATERIAL, .tif LINKS, STATUS CHANGE
(vrml)
CUSTOMER DRAWINGS (.tif, .dxf, .igs)
16
PROCESSING SUBSYSTEM
DRAWING SUBSYSTEM
18
FILE SYSTEM 28
TOOL LIST, SETUP, ETC.
MODELS, DRAWINGS, TOOLPATH
FILE SYSTEM 22
FILE SYSTEM 24
FILE SYSTEM 26

FIG. 2a


START
50
USER
52
WEB
54
56
58
LOOKUP A PREVIOUS
CONFIGURE A NEW
60
ARCHIVE
CONFIGURING SUBSYSTEM
62
64
GENERATE A DRAWING
GET A QUOTE FOR THIS CONFIGURATION
FIND OUT LEAD TIME FOR THIS CONFIGURATION
ORDER THIS CONFIGURATION
FLAT FILE OF CHARACTERISTICS FOR DRAWING SUBSYSTEM
66
FLAT FILE OF CHARACTERISTICS FOR BUSINESS SUBSYSTEM
80
INFORMATION REQUIRED FOR LEAD TIME LOOKUP IN CONFIGURING SUBSYSTEM
90
FLAT FILE OF CHARACTERISTICS FOR BUSINESS SUBSYSTEM
100
A
TO FIG. 2b
B
TO FIG. 2b
C
TO FIG. 2b
D
TO FIG. 2b

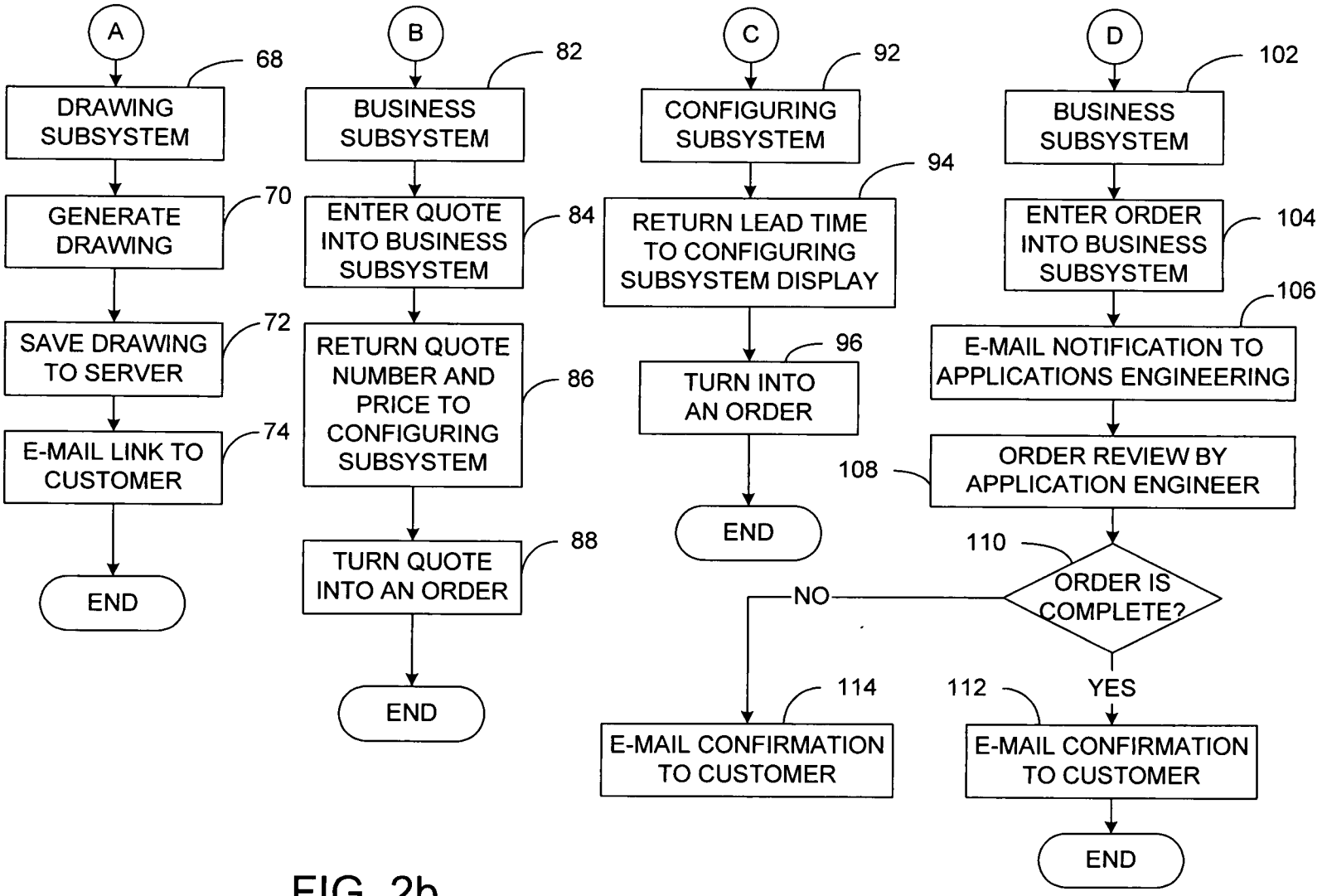

A
DRAWING SUBSYSTEM
68
GENERATE DRAWING
70
SAVE DRAWING TO SERVER
72
E-MAIL LINK TO CUSTOMER
74
END
B
BUSINESS SUBSYSTEM
82
ENTER QUOTE INTO BUSINESS SUBSYSTEM
84
RETURN QUOTE NUMBER AND PRICE TO CONFIGURING SUBSYSTEM
86
TURN QUOTE INTO AN ORDER
88
END
C
CONFIGURING SUBSYSTEM
92
RETURN LEAD TIME TO CONFIGURING SUBSYSTEM DISPLAY
94
TURN INTO AN ORDER
96
END
D
BUSINESS SUBSYSTEM
102
ENTER ORDER INTO BUSINESS SUBSYSTEM
104
E-MAIL NOTIFICATION TO APPLICATIONS ENGINEERING
106
ORDER REVIEW BY APPLICATION ENGINEER
108
ORDER IS COMPLETE?
110
NO
YES
E-MAIL CONFIRMATION TO CUSTOMER
114
E-MAIL CONFIRMATION TO CUSTOMER
112
END

FIG. 2b

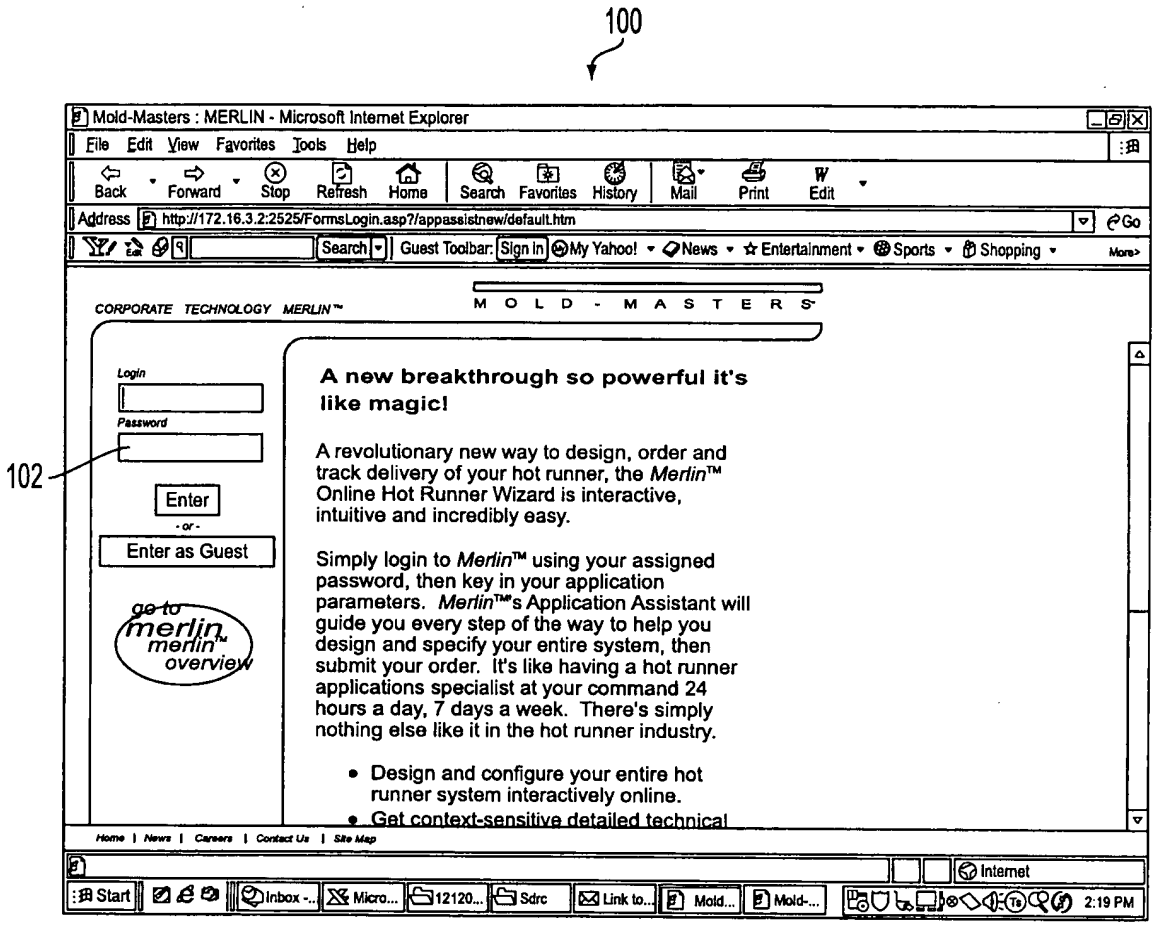

100
Mold-Masters : MERLIN - Microsoft Internet Explorer
File Edit View Favorites Tools Help
Back Forward Stop Refresh Home Search Favorites History Mail Print Edit
Address http://172.16.3.2:2525/FormsLogin.asp?/appassistnew/default.htm
Go
Search Guest Toolbar: Sign In My Yahoo! News Entertainment Sports Shopping More>
CORPORATE TECHNOLOGY MERLIN™
M O L D - M A S T E R S
Login
Password
102
Enter
- or -
Enter as Guest
go to merlin overview
A new breakthrough so powerful it's like magic!
A revolutionary new way to design, order and track delivery of your hot runner, the Merlin™ Online Hot Runner Wizard is interactive, intuitive and incredibly easy.
Simply login to Merlin™ using your assigned password, then key in your application parameters. Merlin™'s Application Assistant will guide you every step of the way to help you design and specify your entire system, then submit your order. It's like having a hot runner applications specialist at your command 24 hours a day, 7 days a week. There's simply nothing else like it in the hot runner industry.
• Design and configure your entire hot runner system interactively online.
• Get context-sensitive detailed technical
Home | News | Careers | Contact Us | Site Map
Internet
Start
Inbox -...
Micro...
12120...
Sdrc
Link to...
Mold...
Mold-...
2:19 PM

FIG. 3

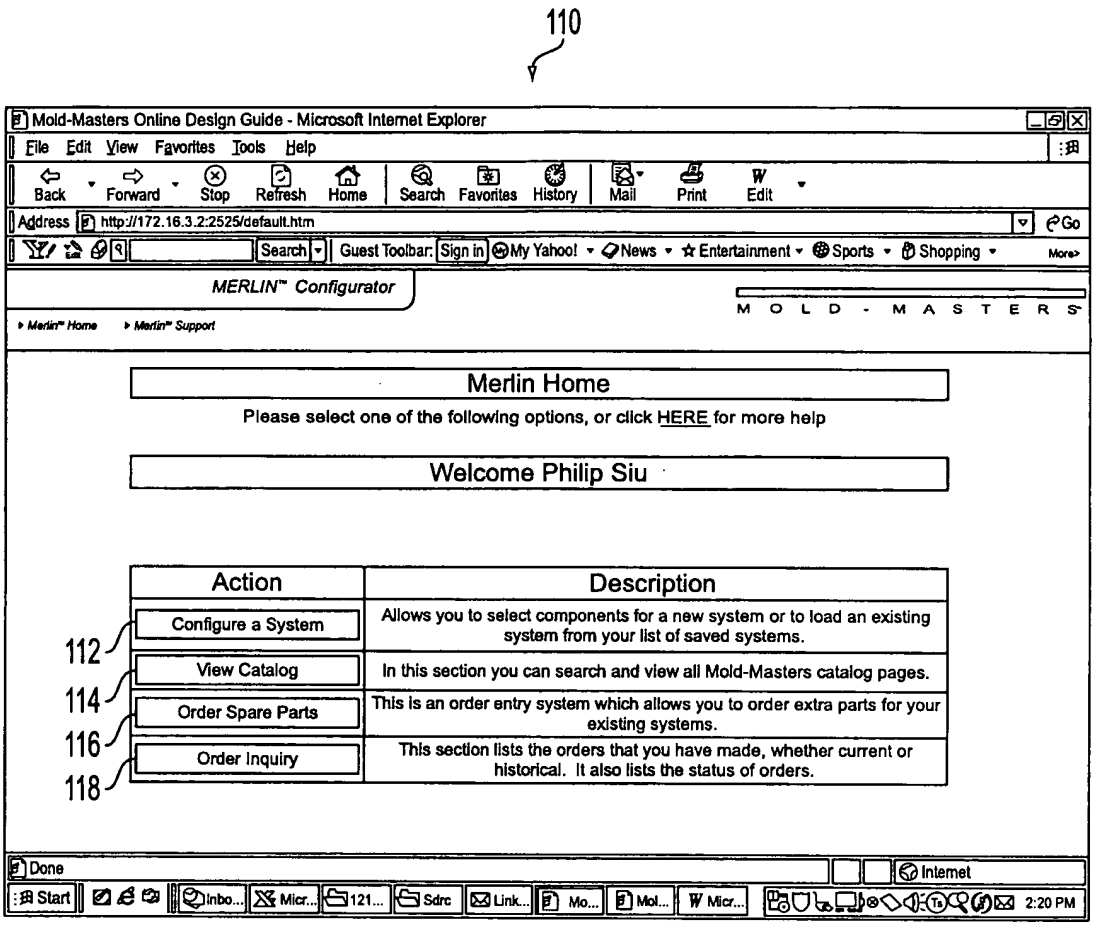

110
Mold-Masters Online Design Guide - Microsoft Internet Explorer
File Edit View Favorites Tools Help
Back Forward Stop Refresh Home Search Favorites History Mail Print Edit
Address http://172.16.3.2:2525/default.htm
Go
Search Guest Toolbar: Sign in My Yahoo! News Entertainment Sports Shopping More
MERLIN™ Configurator
MOLD-MASTERS
Merlin™ Home
Merlin™ Support
Merlin Home
Please select one of the following options, or click HERE for more help
Welcome Philip Siu
Action
Description
Configure a System
Allows you to select components for a new system or to load an existing system from your list of saved systems.
View Catalog
In this section you can search and view all Mold-Masters catalog pages.
Order Spare Parts
This is an order entry system which allows you to order extra parts for your existing systems.
Order Inquiry
This section lists the orders that you have made, whether current or historical. It also lists the status of orders.
112
114
116
118
Done
Internet
Start
2:20 PM

FIG. 4

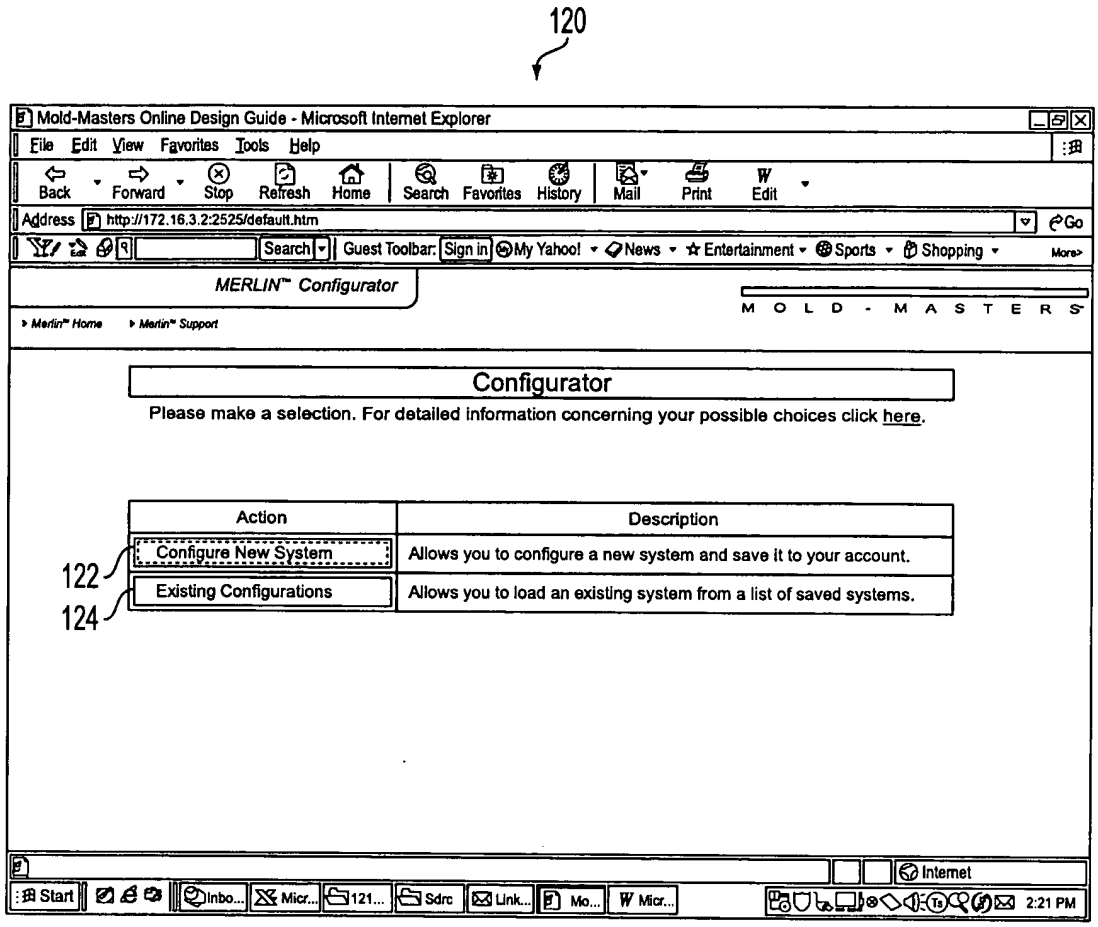

120
Mold-Masters Online Design Guide - Microsoft Internet Explorer
File Edit View Favorites Tools Help
Back Forward Stop Refresh Home Search Favorites History Mail Print Edit
Address http://172.16.3.2:2525/default.htm
Go
Search Guest Toolbar: Sign in My Yahoo! News Entertainment Sports Shopping More>
MERLIN™ Configurator
M O L D - M A S T E R S
Merlin™ Home
Merlin™ Support
Configurator
Please make a selection. For detailed information concerning your possible choices click here.
Action
Description
Configure New System
Allows you to configure a new system and save it to your account.
Existing Configurations
Allows you to load an existing system from a list of saved systems.
122
124
Internet
Start
2:21 PM

FIG. 5

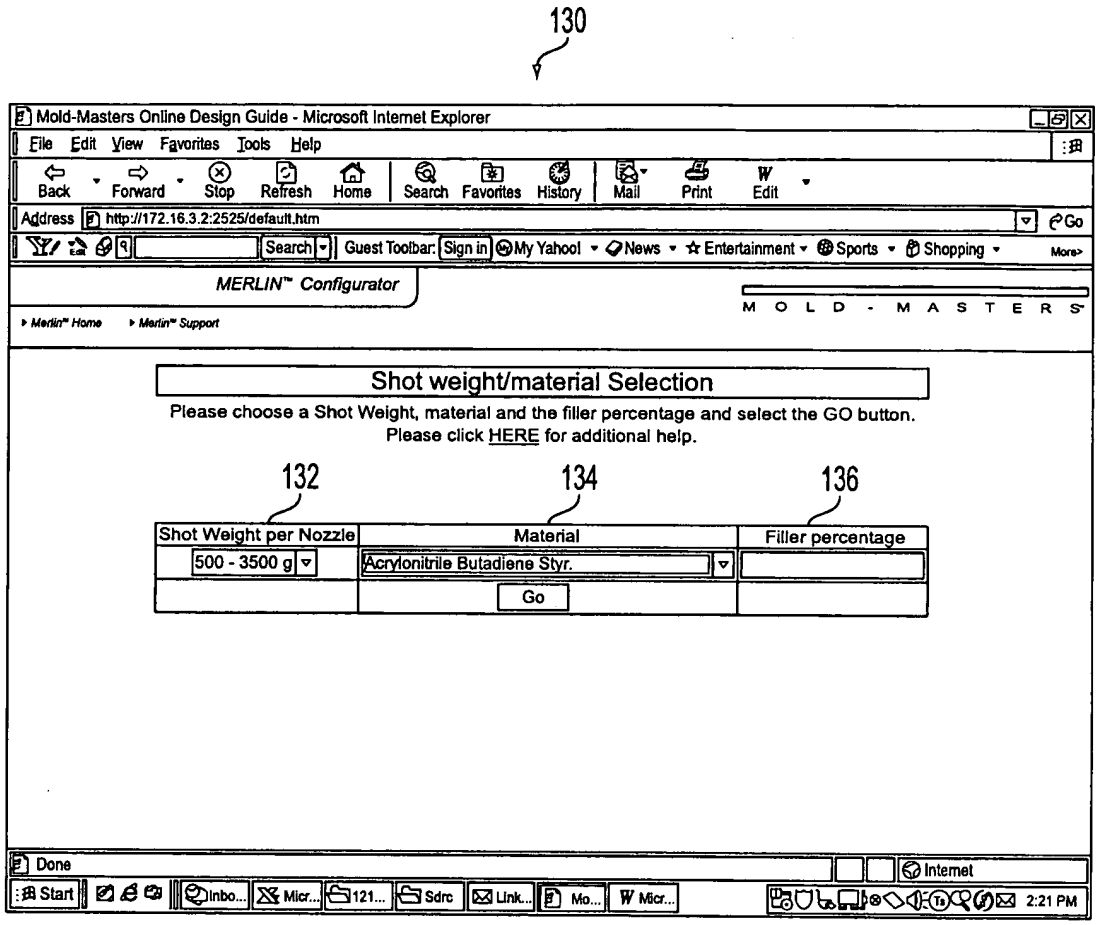

130
Mold-Masters Online Design Guide - Microsoft Internet Explorer
File Edit View Favorites Tools Help
Back Forward Stop Refresh Home Search Favorites History Mail Print Edit
Address http://172.16.3.2:2525/default.htm
Go
Search Guest Toolbar: Sign in My Yahoo! News Entertainment Sports Shopping More>
MERLIN™ Configurator
M O L D - M A S T E R S
Merlin™ Home
Merlin™ Support
Shot weight/material Selection
Please choose a Shot Weight, material and the filler percentage and select the GO button.
Please click HERE for additional help.
132
134
136
Shot Weight per Nozzle
Material
Filler percentage
500 - 3500 g
Acrylonitrile Butadiene Styr.
Go
Done
Internet
Start
2:21 PM

FIG. 6

140

MERLIN™ Configurator

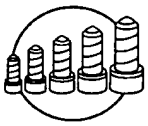
Merlin™ Home | Merlin™ Support

M O L D - M A S T E R S

Product Line Selection

Please select a product line by clicking the button below it. Click here to find out more information.

Previous Step



Dura™

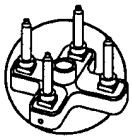
142

Mold Masters established Dura product line of hot runner systems.

MIM Dura-Shot®

144

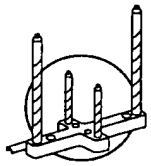
The MIM Dura-Shot ® range of products is based on Mold-Masters established Dura know-how, but with the added advantages of MIM technology.



MIM Speed™

146

Specify, Design and Order your MIM Speed Hot Runner System - Online to provide the fastest delivery of the hot runner system to your specification.



Flex Dura™ System

147

The Flex Dura product line was developed specifically for the automotive and large part molding industries.

FIG. 7

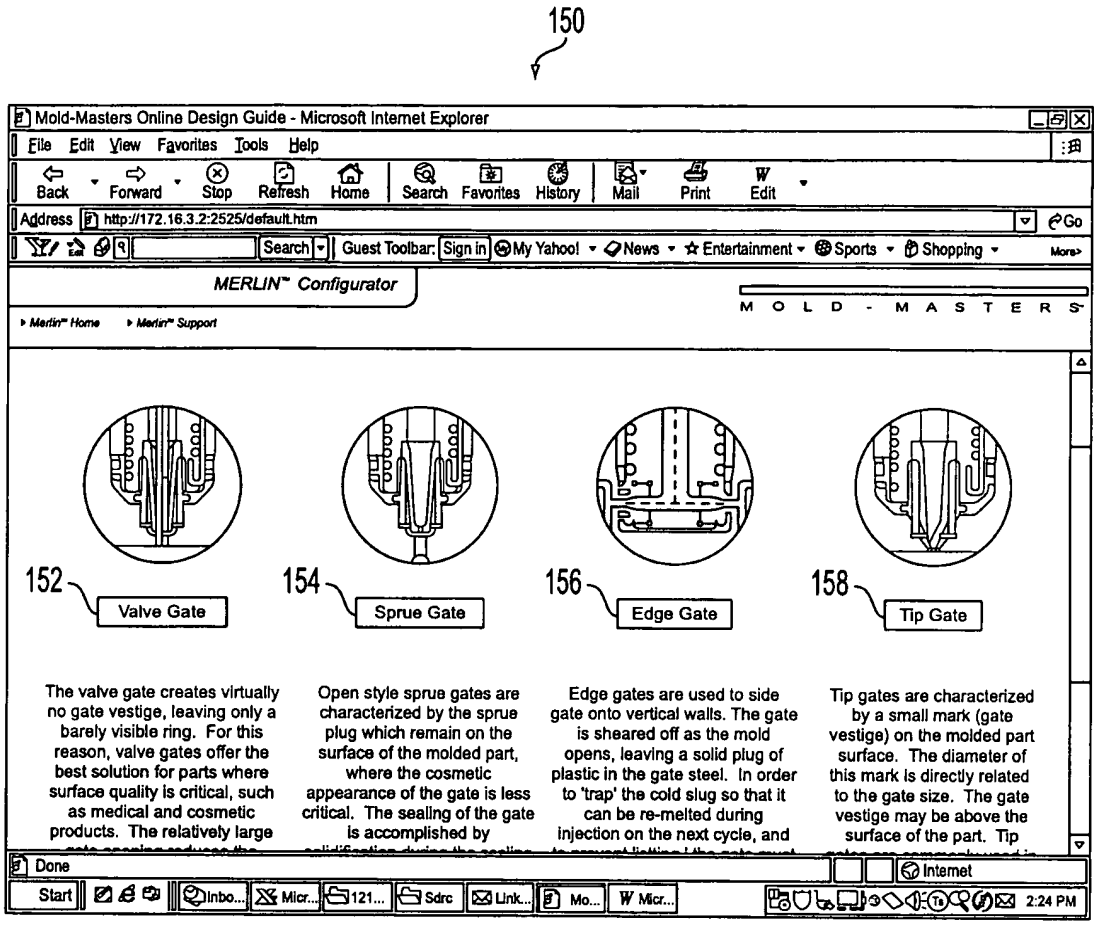

150
Mold-Masters Online Design Guide - Microsoft Internet Explorer
File Edit View Favorites Tools Help
Back Forward Stop Refresh Home Search Favorites History Mail Print Edit
Address http://172.16.3.2:2525/default.htm
Go
Search Guest Toolbar: Sign in My Yahoo! News Entertainment Sports Shopping More>
MERLIN™ Configurator
M O L D - M A S T E R S
Merlin™ Home
Merlin™ Support
152
Valve Gate
154
Sprue Gate
156
Edge Gate
158
Tip Gate
The valve gate creates virtually no gate vestige, leaving only a barely visible ring. For this reason, valve gates offer the best solution for parts where surface quality is critical, such as medical and cosmetic products. The relatively large
Open style sprue gates are characterized by the sprue plug which remain on the surface of the molded part, where the cosmetic appearance of the gate is less critical. The sealing of the gate is accomplished by
Edge gates are used to side gate onto vertical walls. The gate is sheared off as the mold opens, leaving a solid plug of plastic in the gate steel. In order to 'trap' the cold slug so that it can be re-melted during injection on the next cycle, and
Tip gates are characterized by a small mark (gate vestige) on the molded part surface. The diameter of this mark is directly related to the gate size. The gate vestige may be above the surface of the part. Tip
Done
Internet
Start
Inbo... Micr... 121... Sdrc Link... Mo... Micr...
2:24 PM

FIG. 8

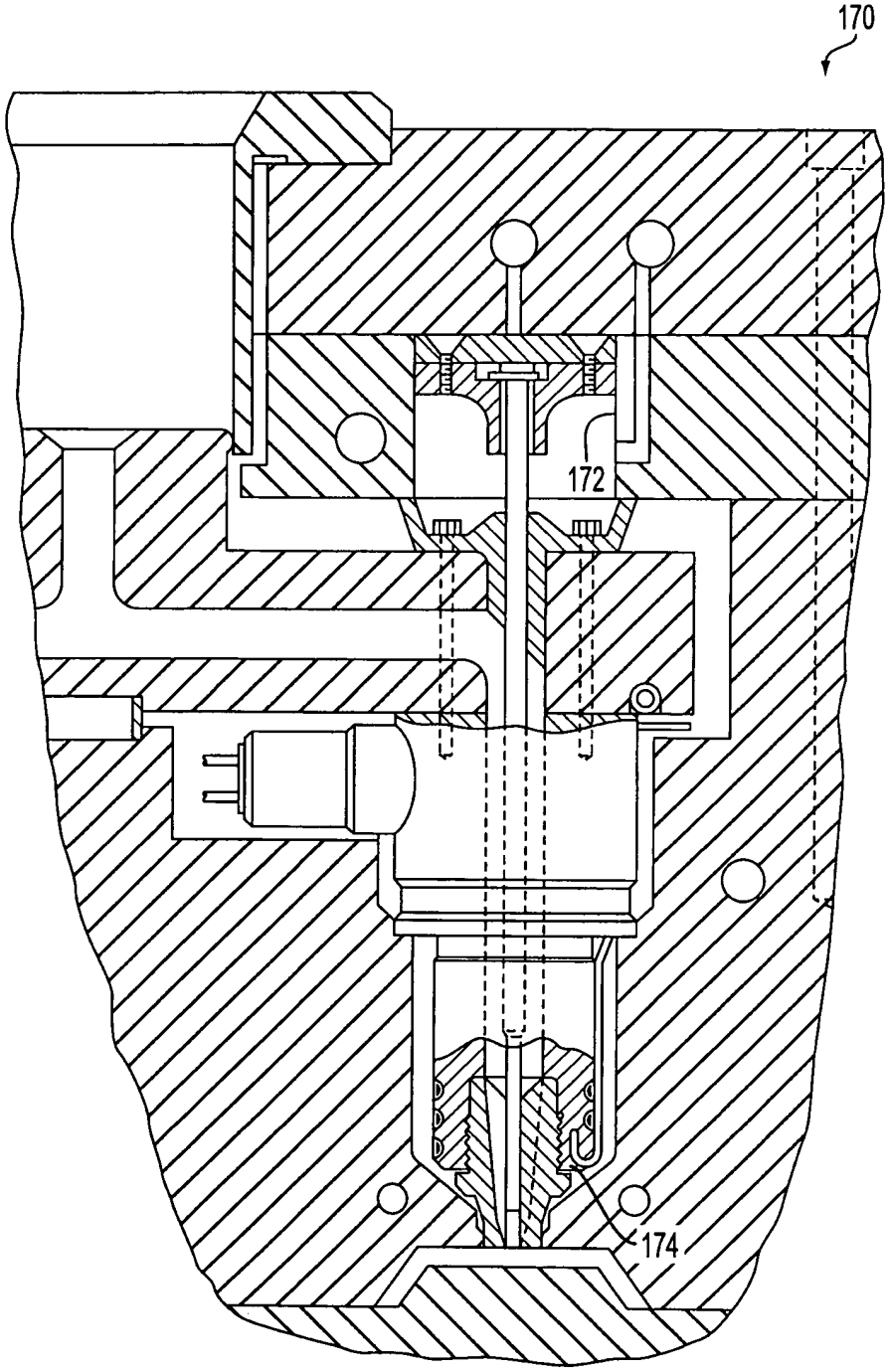


FIG. 9

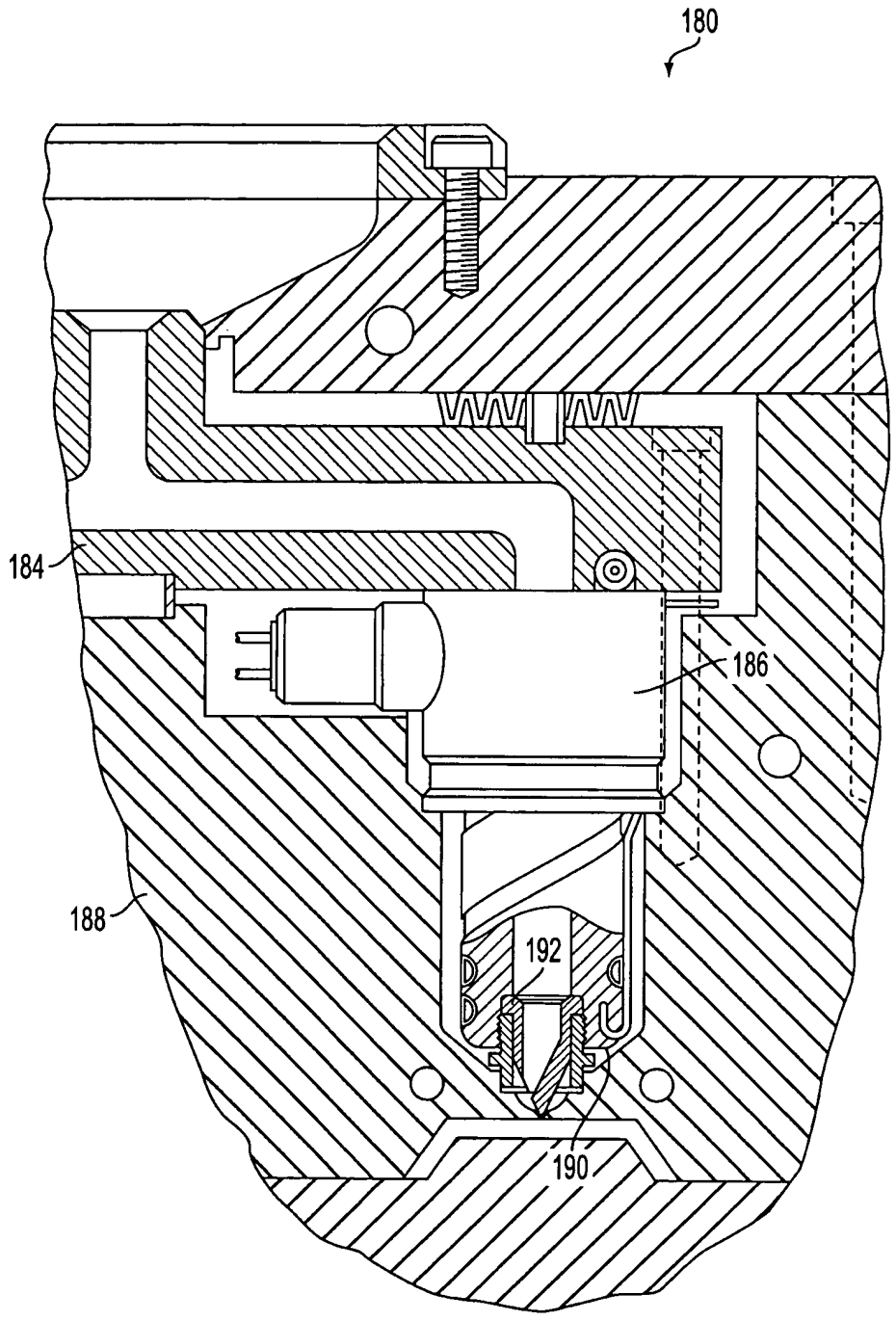


FIG. 10

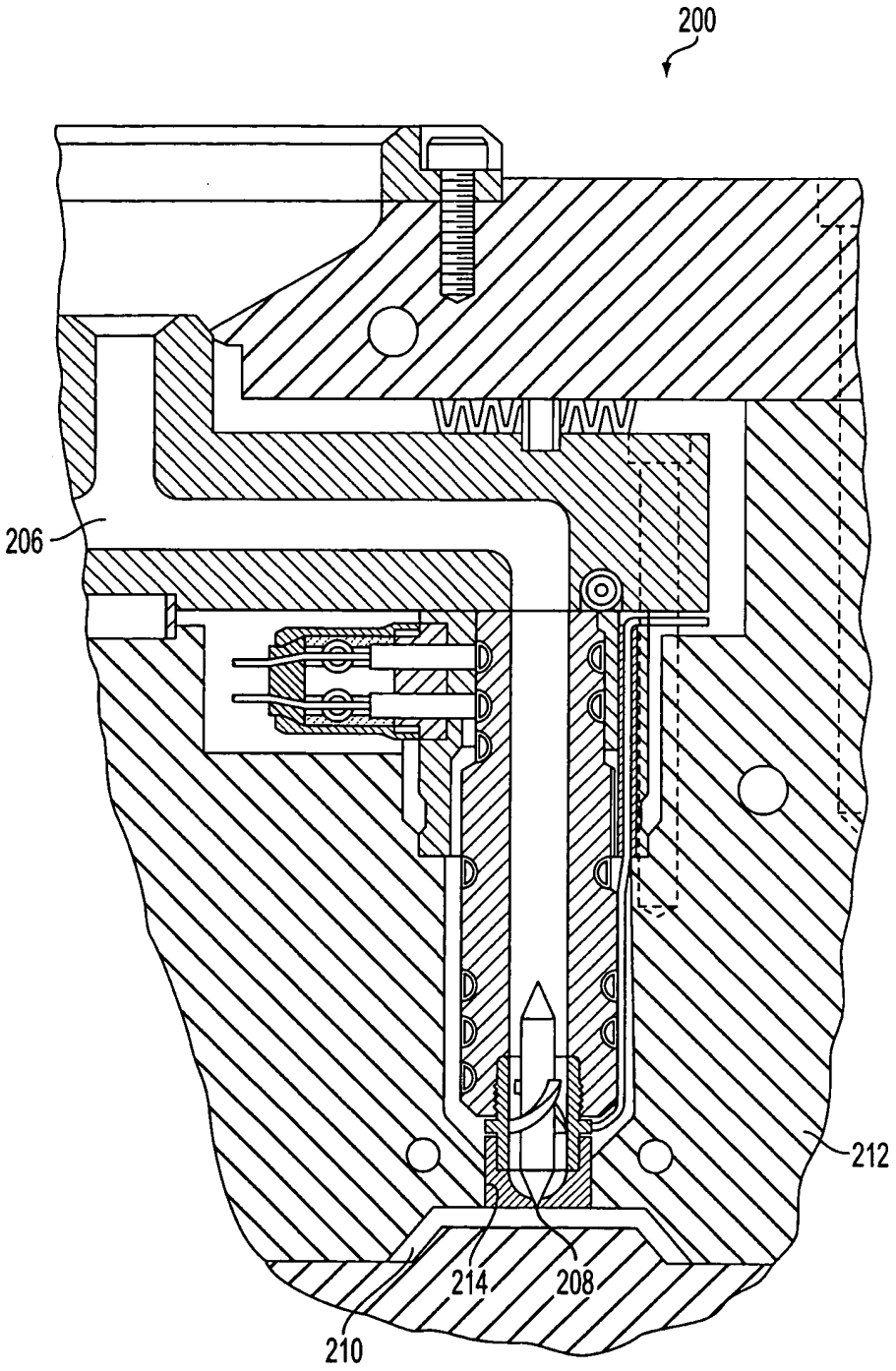


FIG. 11

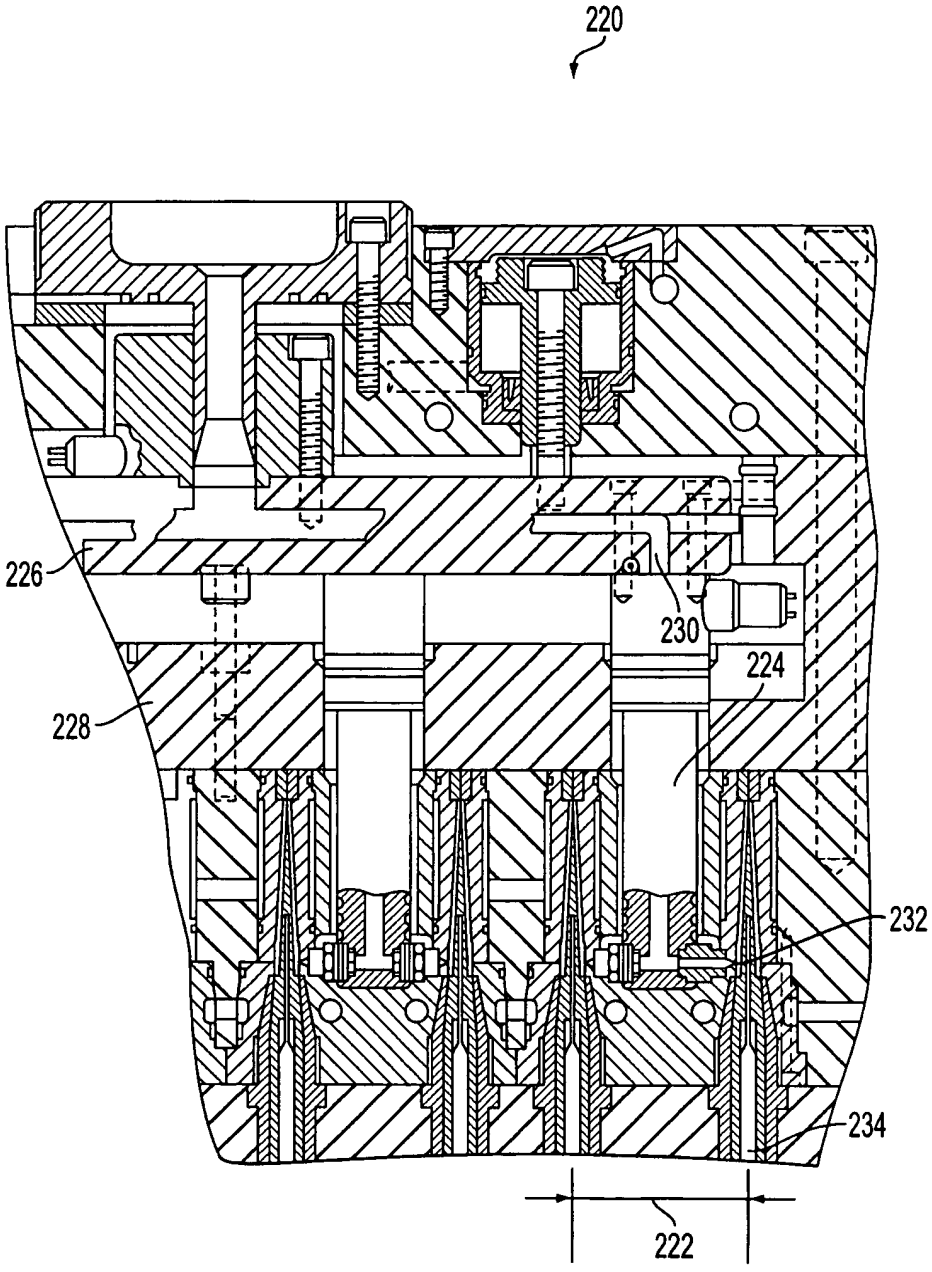


FIG. 12

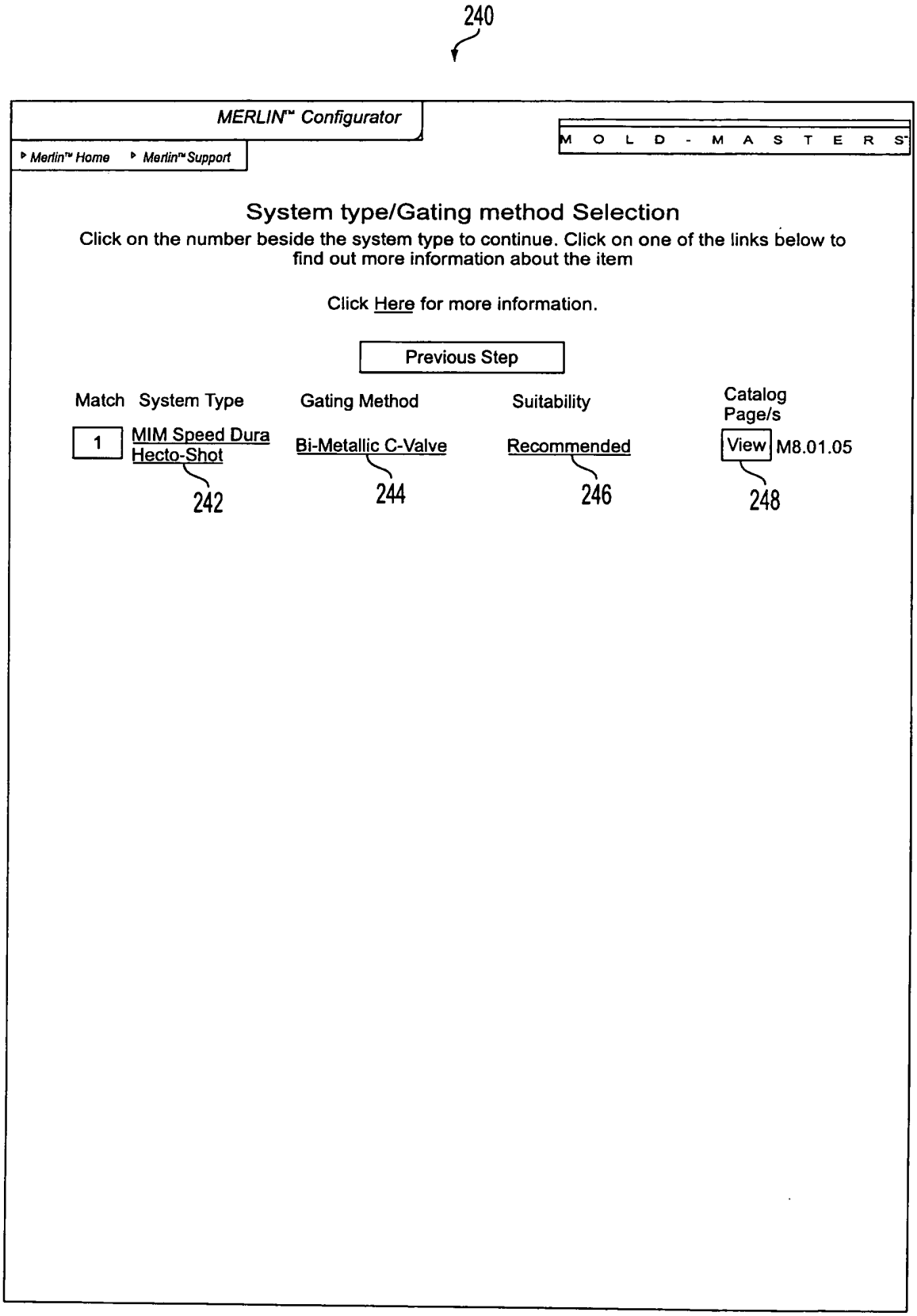

240
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
System type/Gating method Selection
Click on the number beside the system type to continue. Click on one of the links below to find out more information about the item
Click Here for more information.
Previous Step
Match
System Type
Gating Method
Suitability
Catalog Page/s
1
MIM Speed Dura Hecto-Shot
Bi-Metallic C-Valve
Recommended
View
M8.01.05
242
244
246
248

FIG. 13

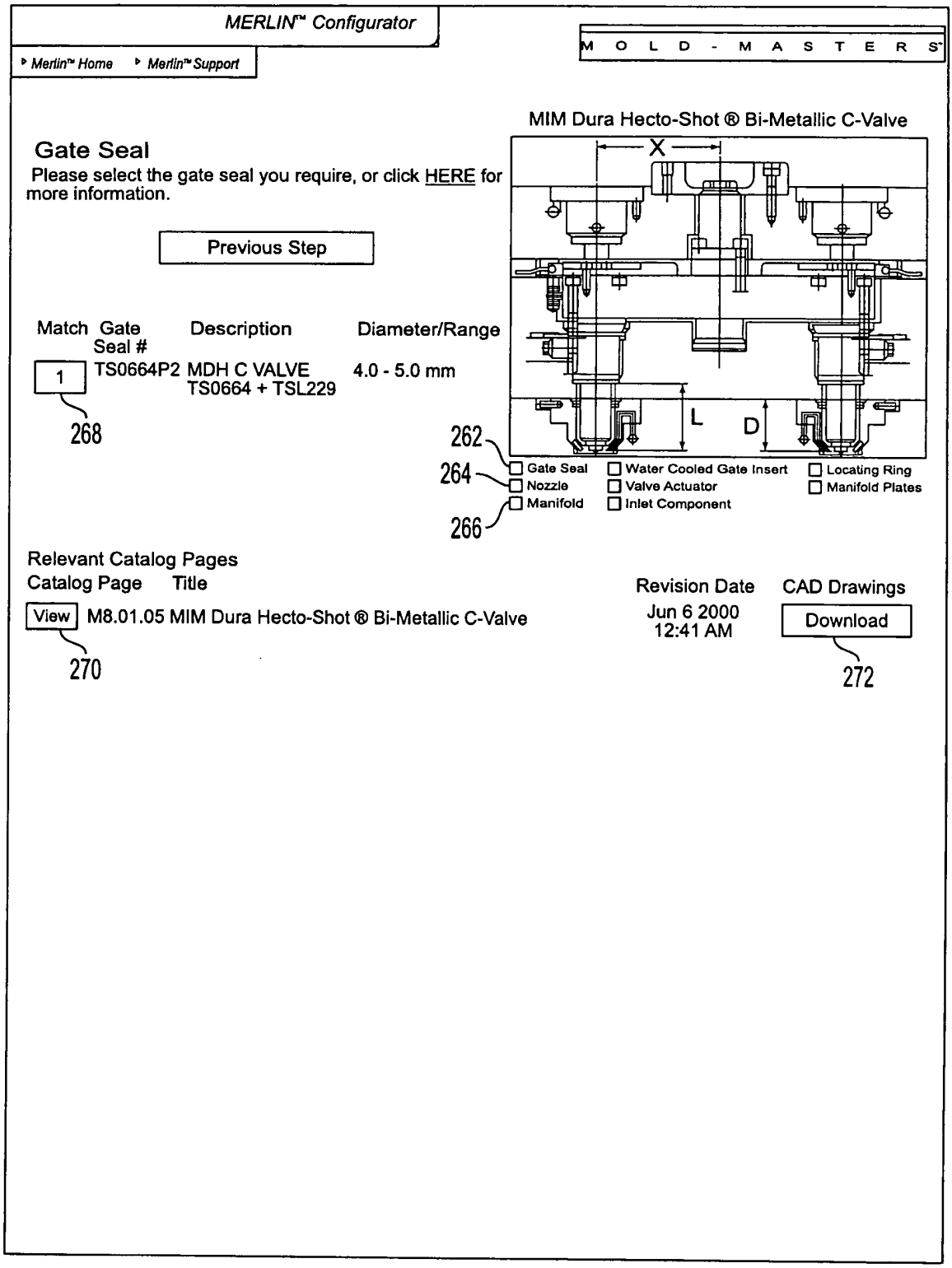

260
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Gate Seal
Please select the gate seal you require, or click HERE for more information.
Previous Step
Match
Gate Seal #
Description
Diameter/Range
1
TS0664P2
MDH C VALVE
TS0664 + TSL229
4.0 - 5.0 mm
268
X
L
D
262
264
266
Gate Seal
Nozzle
Manifold
Water Cooled Gate Insert
Valve Actuator
Inlet Component
Locating Ring
Manifold Plates
Relevant Catalog Pages
Catalog Page
Title
View
M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
270
Revision Date
Jun 6 2000
12:41 AM
CAD Drawings
Download
272

FIG. 14

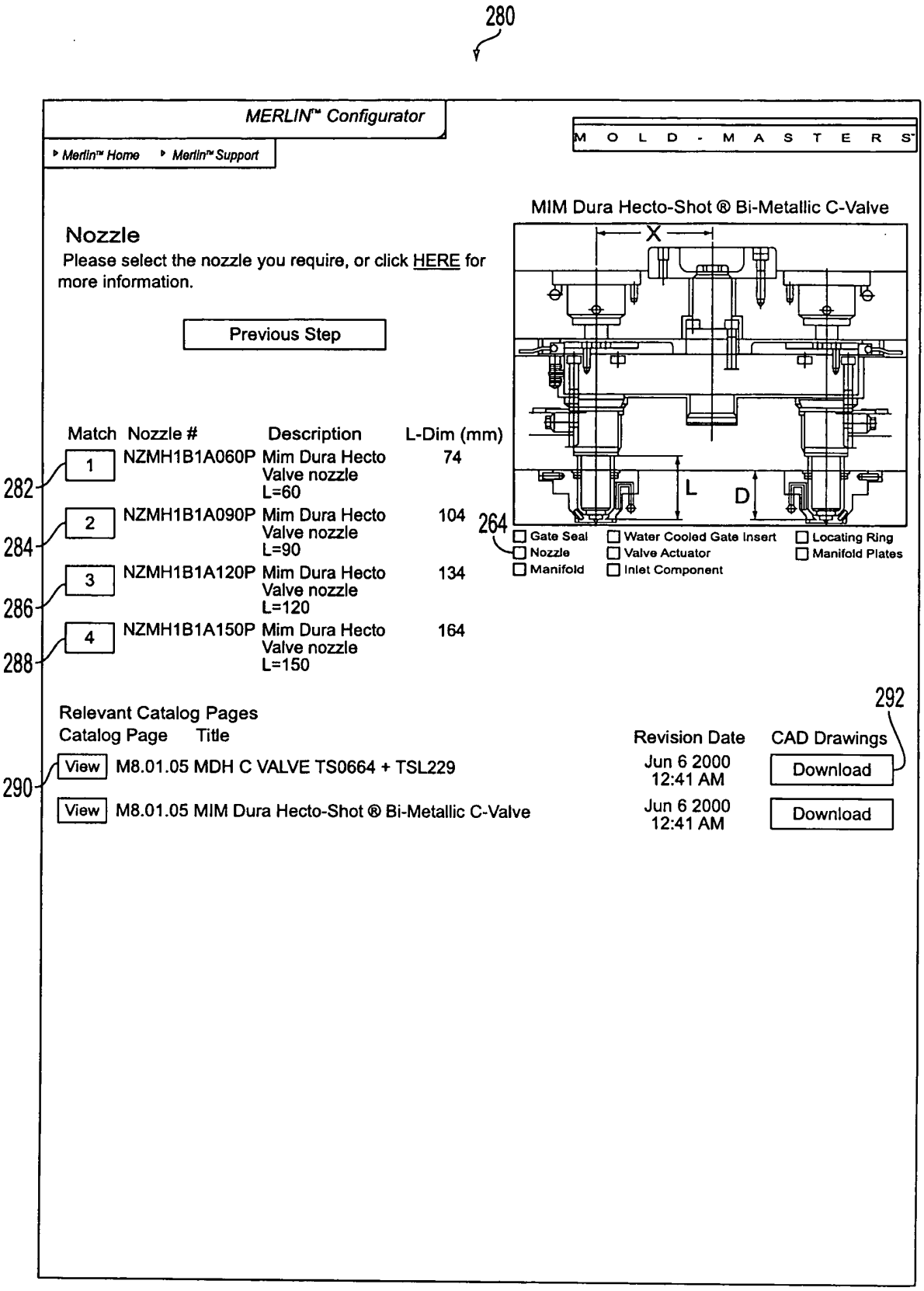

280
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Nozzle
Please select the nozzle you require, or click HERE for more information.
Previous Step
X
L
D
264
Gate Seal
Nozzle
Manifold
Water Cooled Gate Insert
Valve Actuator
Inlet Component
Locating Ring
Manifold Plates
Match
Nozzle #
Description
L-Dim (mm)
282
1
NZMH1B1A060P
Mim Dura Hecto Valve nozzle L=60
74
284
2
NZMH1B1A090P
Mim Dura Hecto Valve nozzle L=90
104
286
3
NZMH1B1A120P
Mim Dura Hecto Valve nozzle L=120
134
288
4
NZMH1B1A150P
Mim Dura Hecto Valve nozzle L=150
164
292
Relevant Catalog Pages
Catalog Page
Title
Revision Date
CAD Drawings
290
View
M8.01.05 MDH C VALVE TS0664 + TSL229
Jun 6 2000 12:41 AM
Download
View
M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Jun 6 2000 12:41 AM
Download

FIG. 15

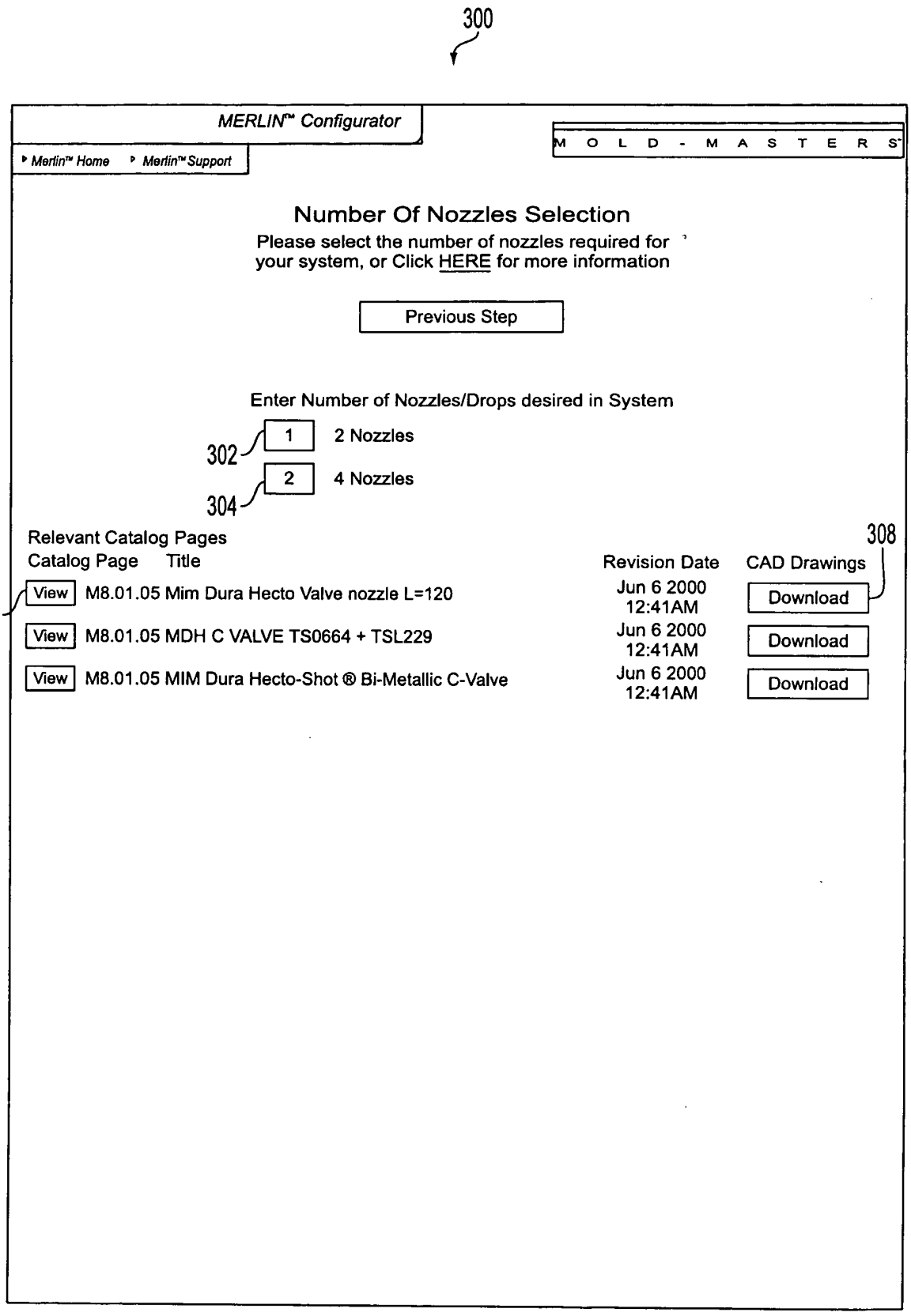

300
MERLIN™ Configurator
M O L D - M A S T E R S
Merlin™ Home
Merlin™ Support
Number Of Nozzles Selection
Please select the number of nozzles required for your system, or Click HERE for more information
Previous Step
Enter Number of Nozzles/Drops desired in System
302
1
2 Nozzles
304
2
4 Nozzles
308
Relevant Catalog Pages
Catalog Page
Title
Revision Date
CAD Drawings
306
View
M8.01.05 Mim Dura Hecto Valve nozzle L=120
Jun 6 2000 12:41AM
Download
View
M8.01.05 MDH C VALVE TS0664 + TSL229
Jun 6 2000 12:41AM
Download
View
M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Jun 6 2000 12:41AM
Download

FIG. 16

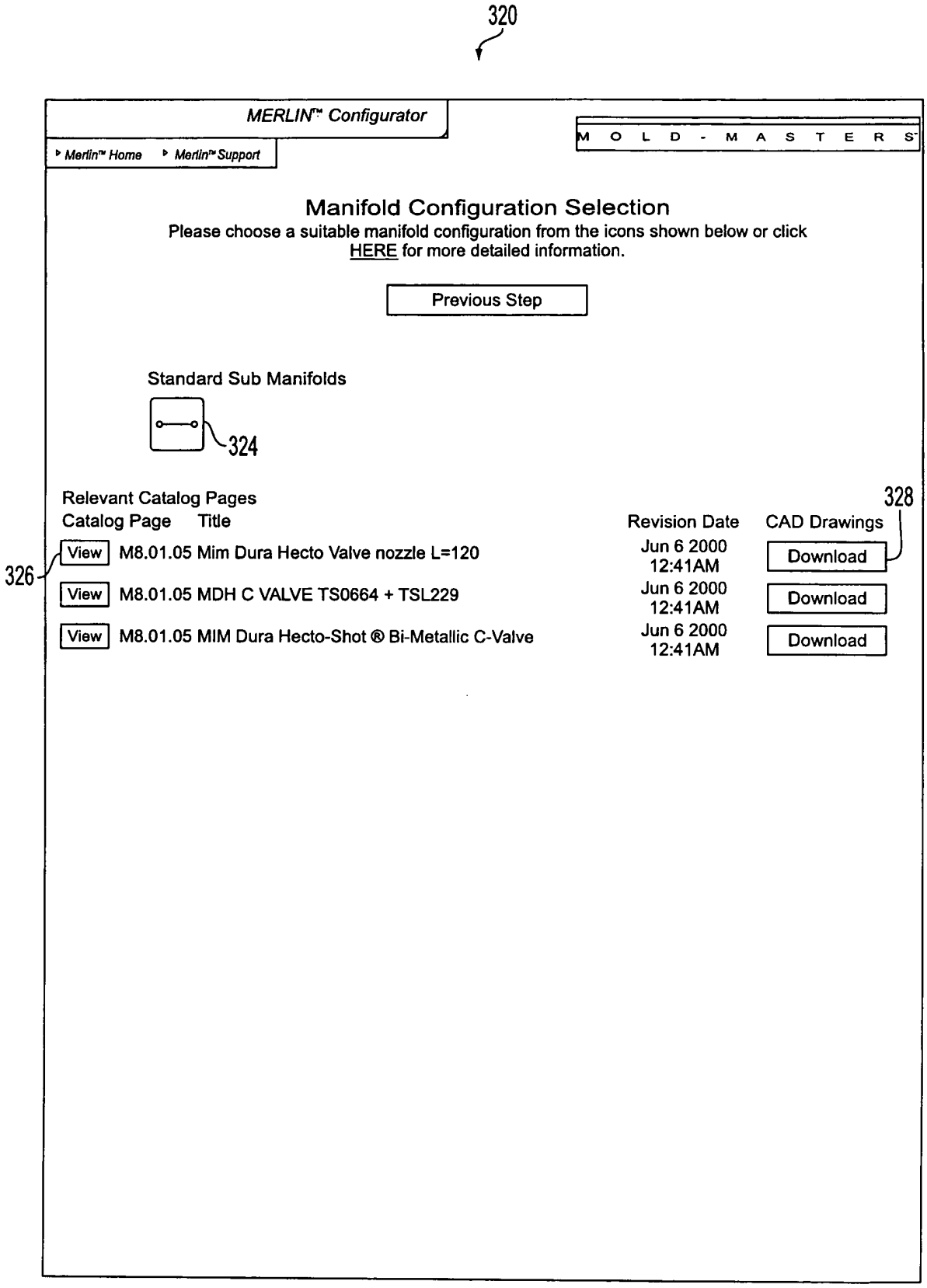

320
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
Manifold Configuration Selection
Please choose a suitable manifold configuration from the icons shown below or click HERE for more detailed information.
Previous Step
Standard Sub Manifolds
324
Relevant Catalog Pages
328
Catalog Page
Title
Revision Date
CAD Drawings
326
View
M8.01.05 Mim Dura Hecto Valve nozzle L=120
Jun 6 2000 12:41AM
Download
View
M8.01.05 MDH C VALVE TS0664 + TSL229
Jun 6 2000 12:41AM
Download
View
M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Jun 6 2000 12:41AM
Download

FIG. 17

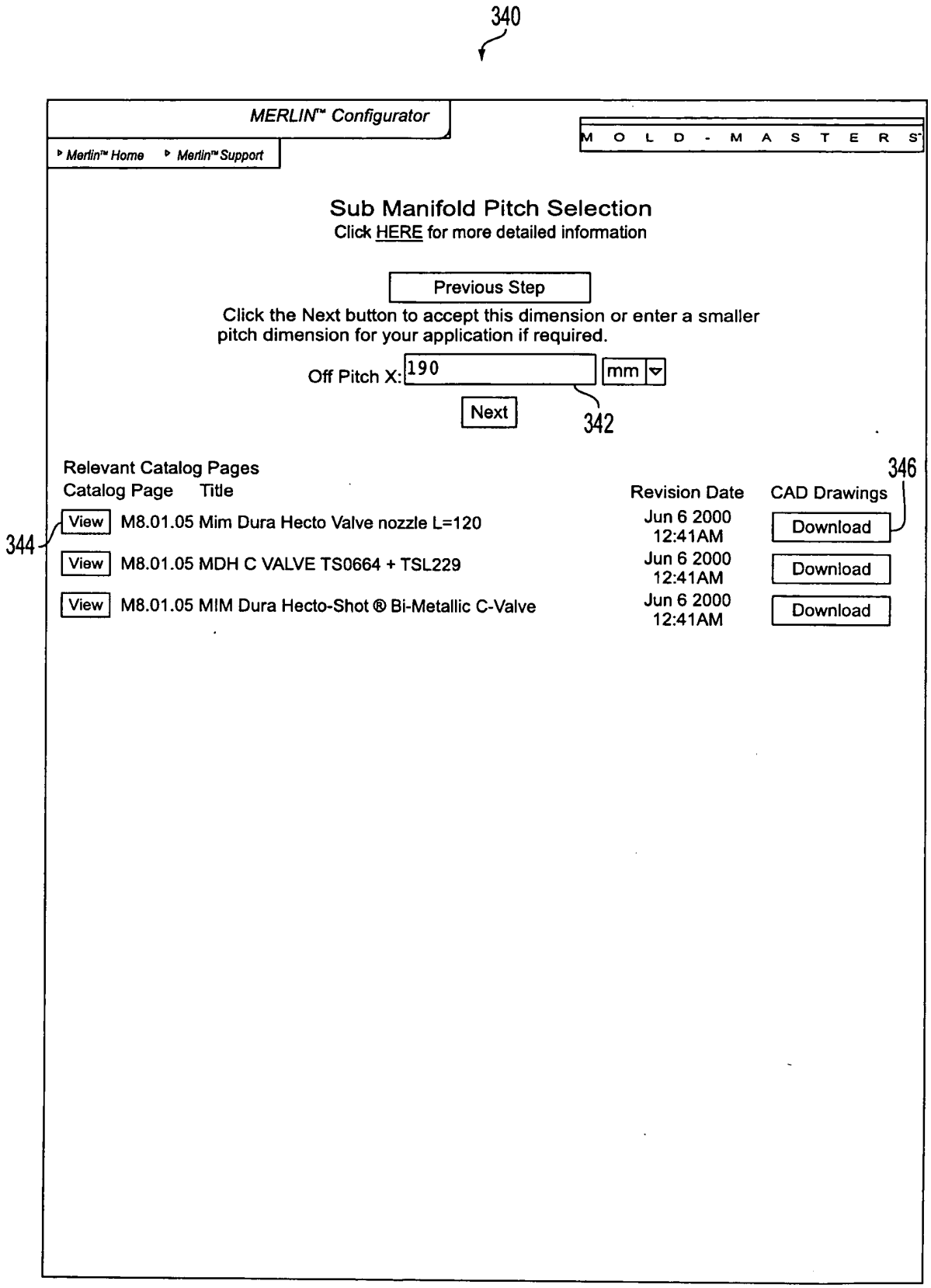

340
MERLIN™ Configurator
M O L D - M A S T E R S
Merlin™ Home
Merlin™ Support
Sub Manifold Pitch Selection
Click HERE for more detailed information
Previous Step
Click the Next button to accept this dimension or enter a smaller pitch dimension for your application if required.
Off Pitch X:
190
mm
Next
342
Relevant Catalog Pages
Catalog Page
Title
Revision Date
CAD Drawings
346
344
View
M8.01.05 Mim Dura Hecto Valve nozzle L=120
Jun 6 2000 12:41AM
Download
View
M8.01.05 MDH C VALVE TS0664 + TSL229
Jun 6 2000 12:41AM
Download
View
M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Jun 6 2000 12:41AM
Download

FIG. 18

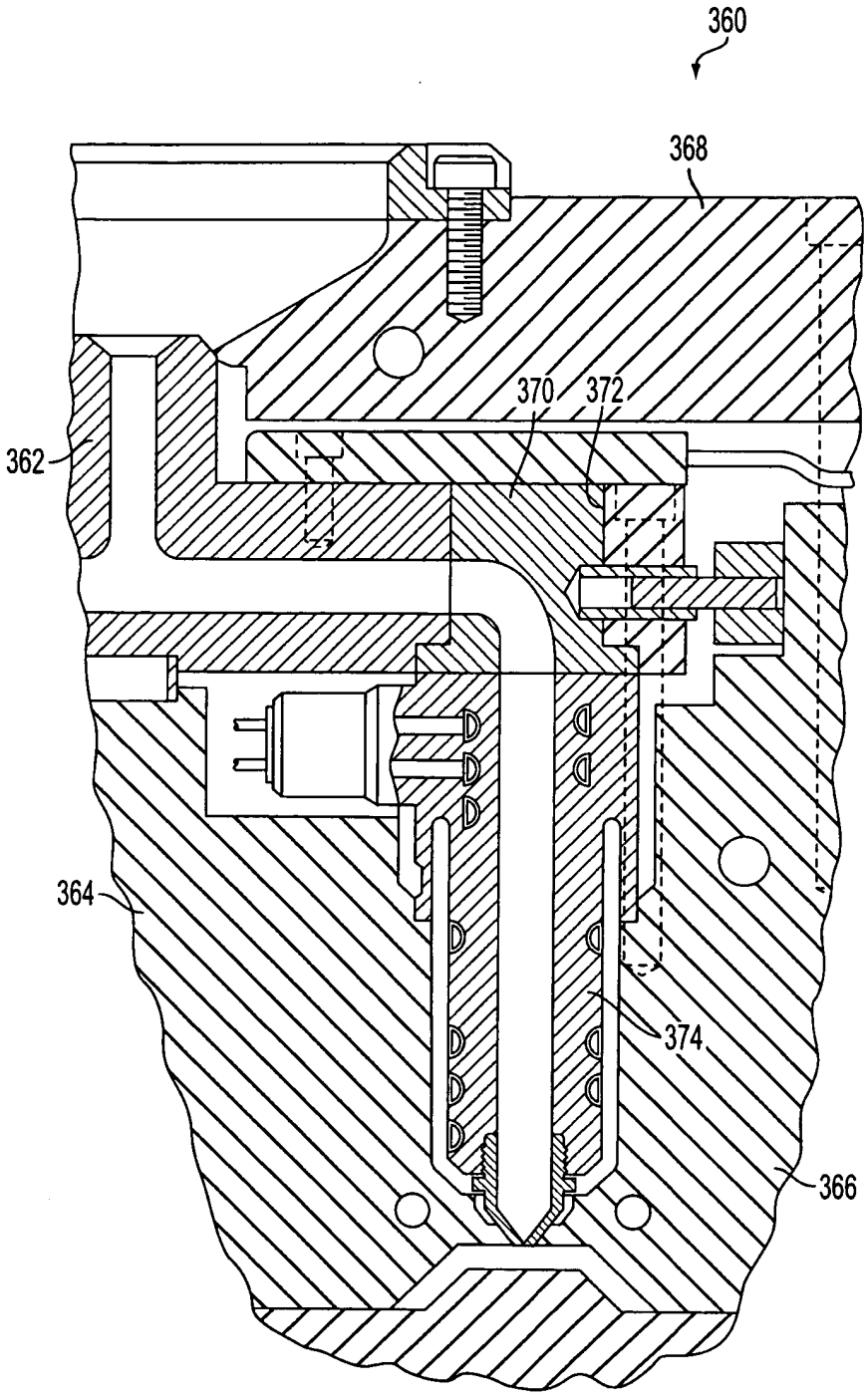


FIG. 19

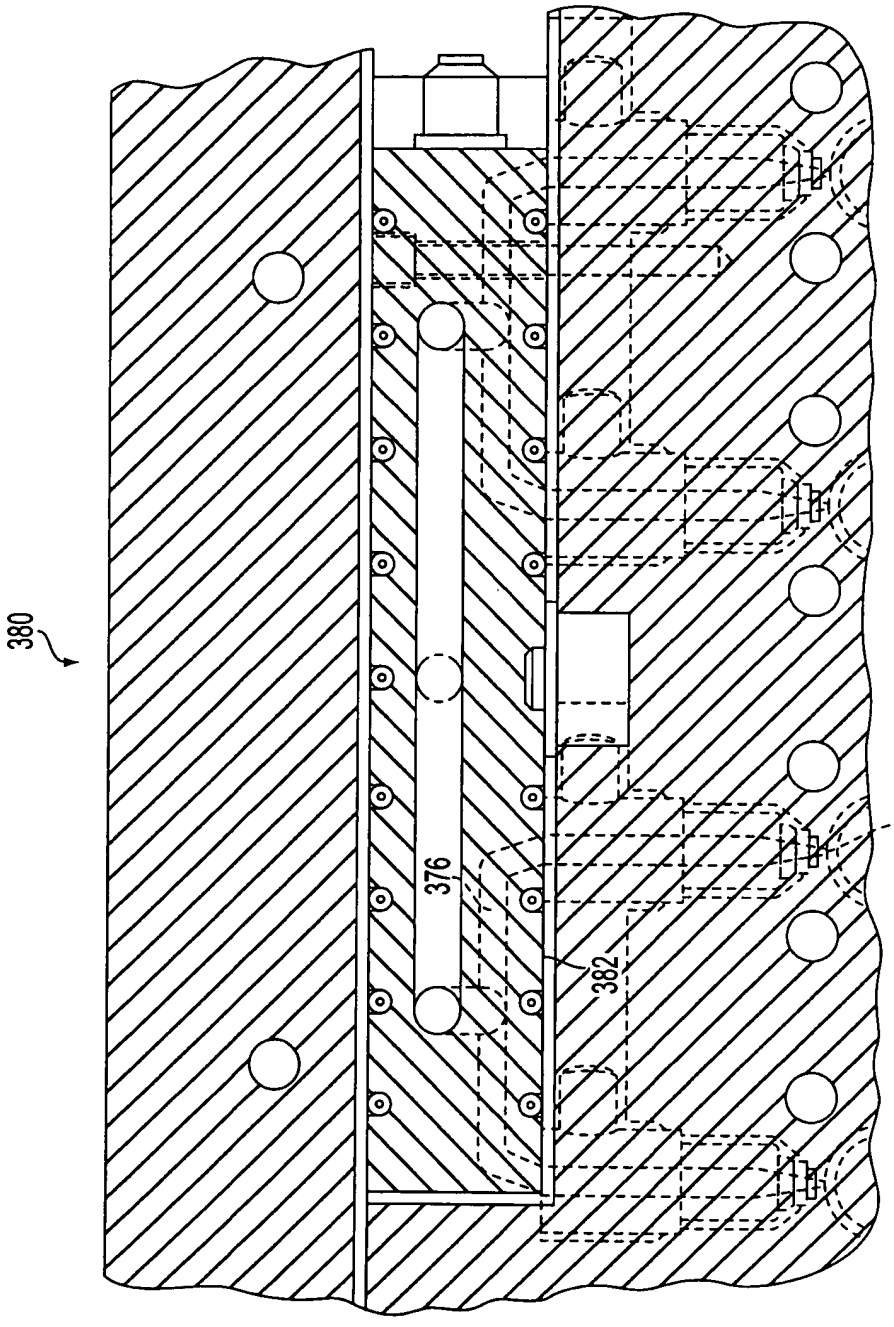


FIG. 20

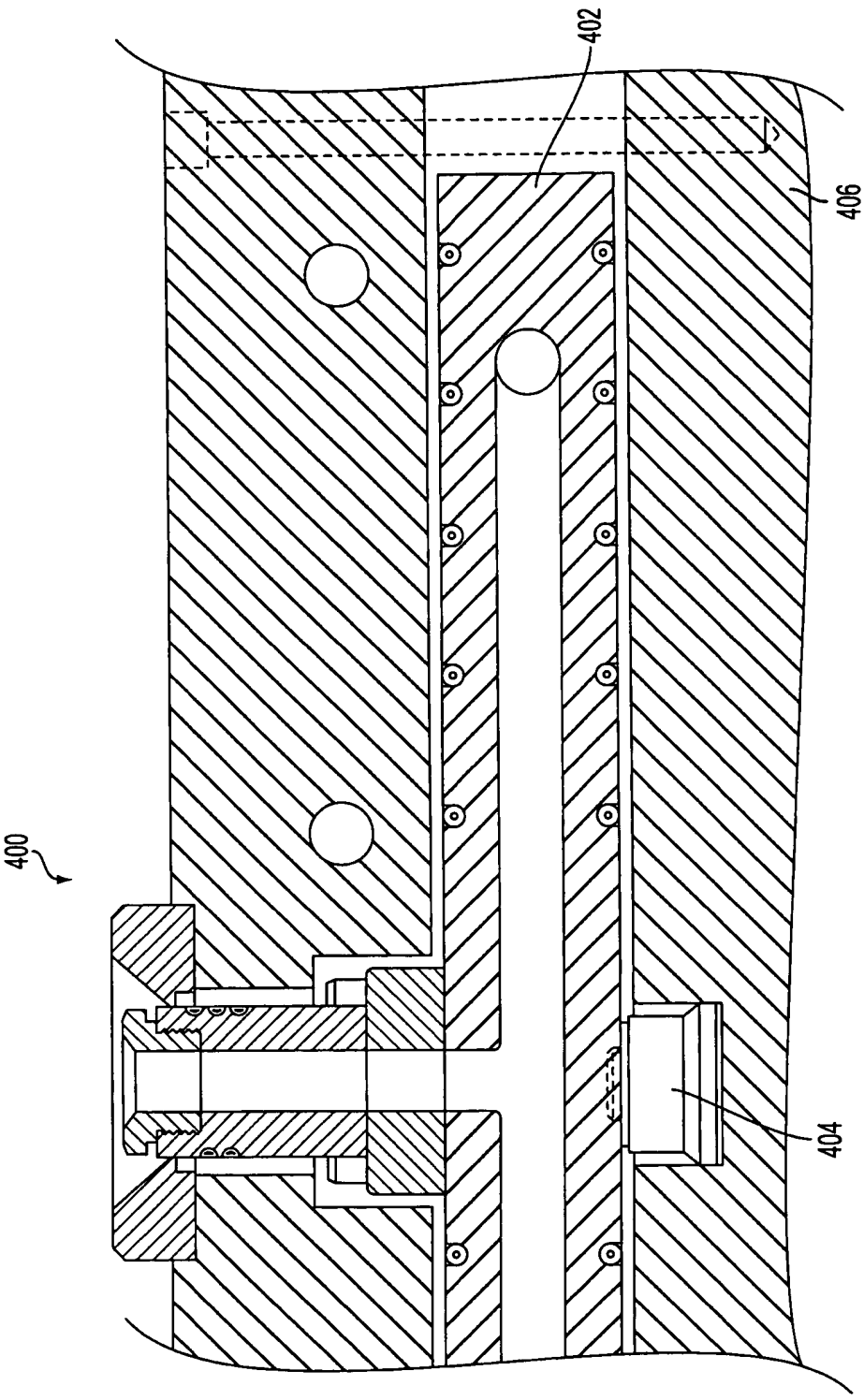


FIG. 21

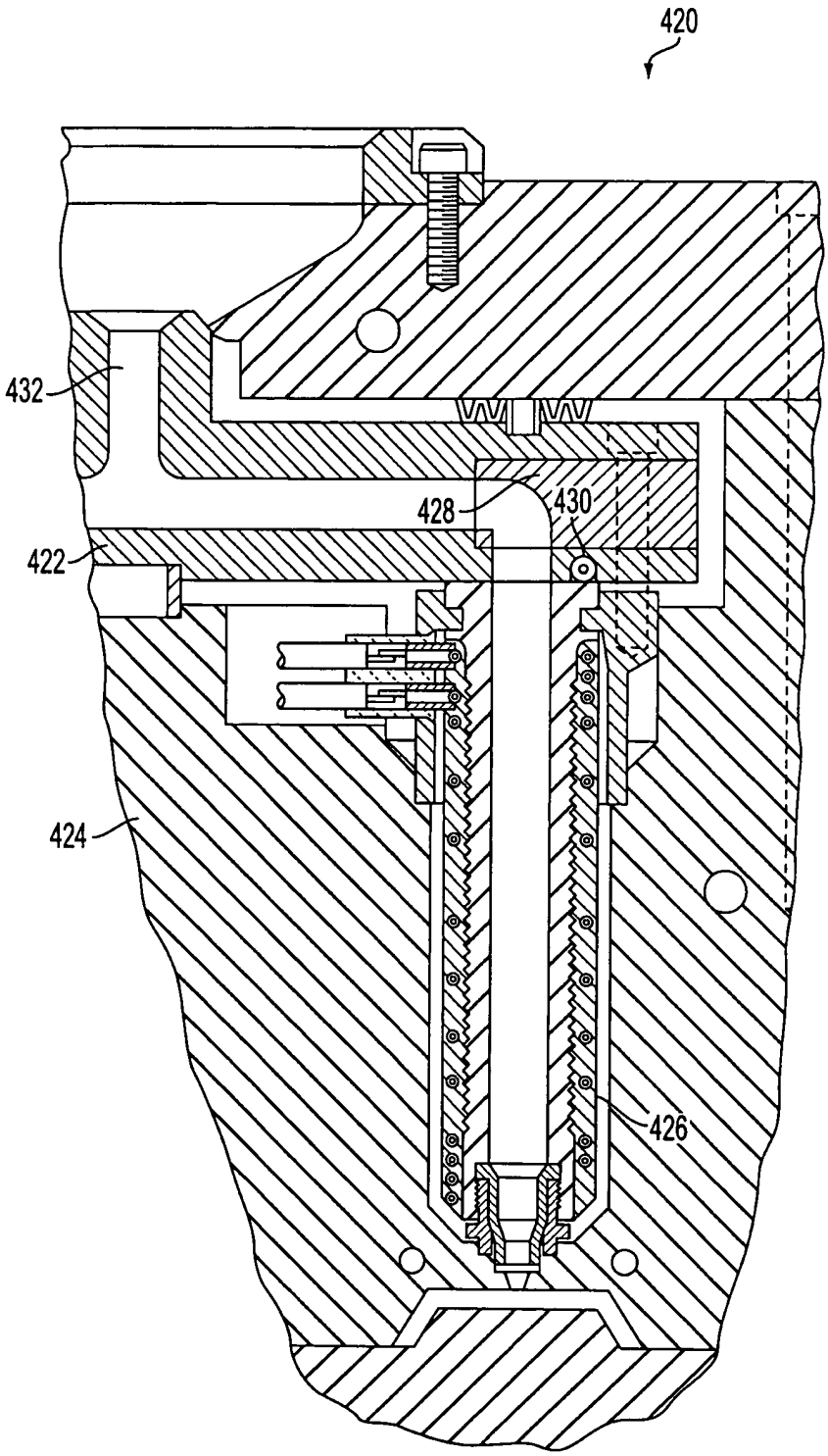


FIG. 22

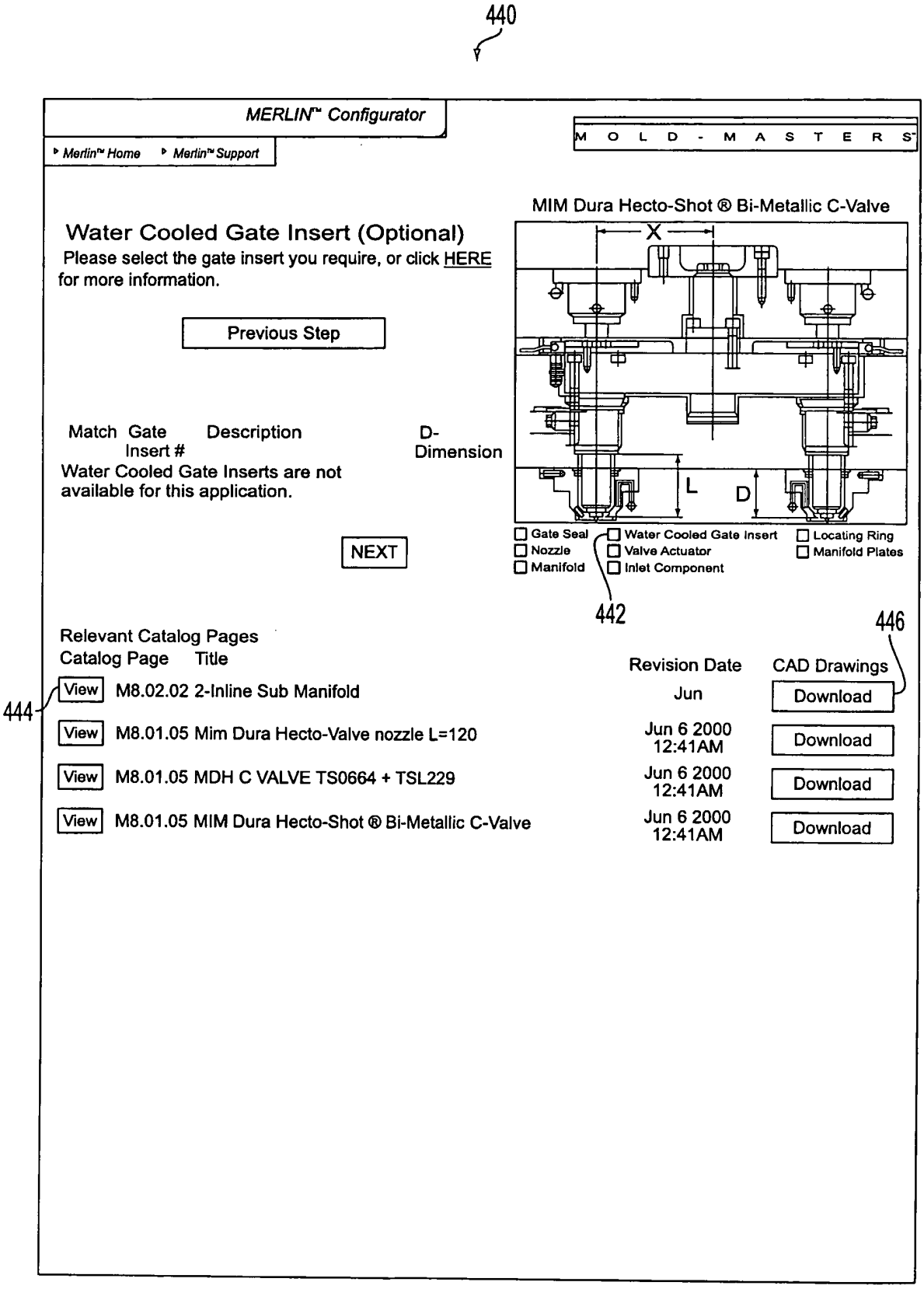

440
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Water Cooled Gate Insert (Optional)
Please select the gate insert you require, or click HERE for more information.
Previous Step
Match Gate Insert #
Description
D-Dimension
Water Cooled Gate Inserts are not available for this application.
NEXT
X
L
D
Gate Seal
Nozzle
Manifold
Water Cooled Gate Insert
Valve Actuator
Inlet Component
Locating Ring
Manifold Plates
442
446
Relevant Catalog Pages
Catalog Page
Title
Revision Date
CAD Drawings
444
View
M8.02.02 2-Inline Sub Manifold
Jun
Download
View
M8.01.05 Mim Dura Hecto-Valve nozzle L=120
Jun 6 2000 12:41AM
Download
View
M8.01.05 MDH C VALVE TS0664 + TSL229
Jun 6 2000 12:41AM
Download
View
M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Jun 6 2000 12:41AM
Download

FIG. 23

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MERLIN™ Configurator

Merlin™ Home | Merlin™ Support

M O L D - M A S T E R S™

MIM Dura Hecto-Shot ® Bi-Metallic C-V

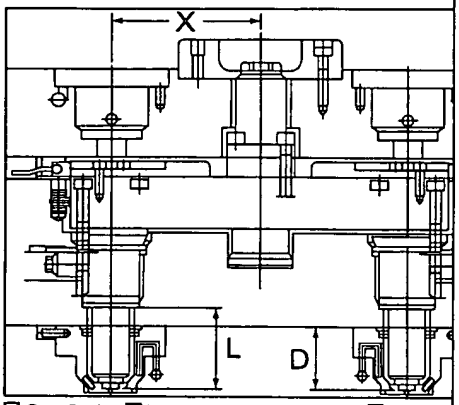
Valve Actuator

Please select the valve actuator you require, or click HERE for more information.

Previous Step

Match	Valve Actuator #	Description	Valve Pin Max. Length	Valve Pin Diameter	Valve Pin Stroke
1	HY6600D	Hydraulic/Pneumatic Cylinder Assembly	355.0 mm	7.940 mm	20.0 mm

464



☐ Gate Seal ☐ Water Cooled Gate Insert ☐ Locating
☐ Nozzle ☐ Valve Actuator ☐ Manifold
☐ Manifold ☐ Inlet Component

462

468

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	Download

466

FIG. 24

480

MERLIN™ Configurator

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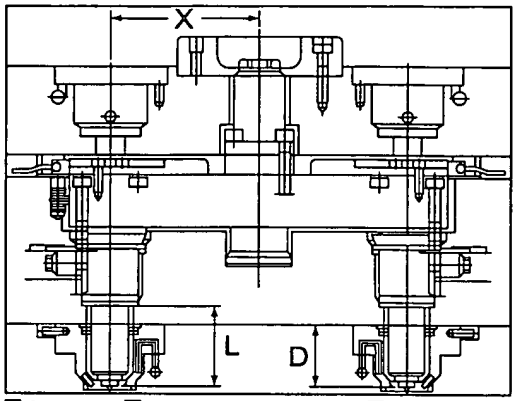
MOLD-MASTERS

MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

Inlet Component

Please select the Inlet Component you require, or click HERE for more information.

Previous Step



☐ Gate Seal ☐ Water Cooled Gate Insert ☐ Locating Ring
☐ Nozzle ☐ Valve Actuator ☐ Manifold Plates
☐ Manifold ☐ Inlet Component

482

Matches Description

1 Manifold center heater

484

488

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41 AM	Download

486

FIG. 25

500

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M O L D - M A S T E R S™

MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

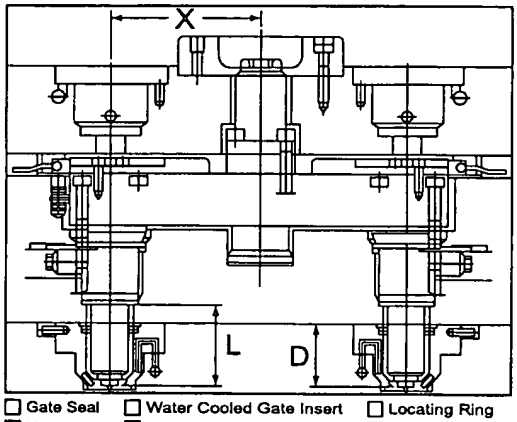
Inlet Component Manifold center heater

Please select the Inlet Component you require, or click HERE for more information.

Previous Step

Matches	Inlet Component #	Machine Nozzle Radius
1	BP58.500P	0.5 inch
2	BP58.750P	0.75 inch

502



☐ Gate Seal ☐ Water Cooled Gate Insert ☐ Locating Ring
☐ Nozzle ☐ Valve Actuator ☐ Manifold Plates
☐ Manifold ☐ Inlet Component

506

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41 AM	Download

504

FIG. 26

520

MERLIN™ Configurator

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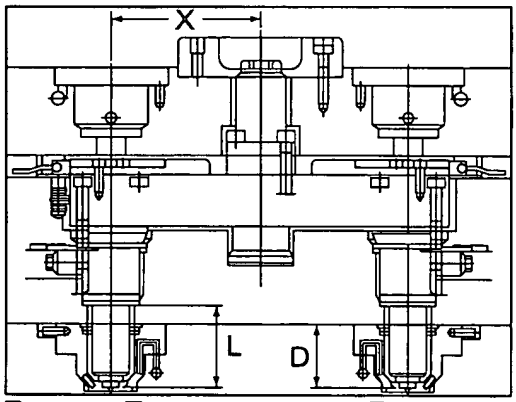
M O L D - M A S T E R S

Location Ring

Please select the locating ring you require, or click HERE for more information.

Previous Step

MIM Dura Hecto-Shot ® Bi-Metallic C-Valve



☐ Gate Seal ☐ Water Cooled Gate Insert ☐ Locating Ring
☐ Nozzle ☐ Valve Actuator ☐ Manifold Plates
☐ Manifold ☐ Inlet Component

522

524

Matches	Locating Ring #	Description	Diameter (mm)
1	LR0070	Loc. ring for machine nozzle pad	101.34
2	LR0071	Loc. ring for machine nozzle pad	109.75
3	LR0081	Locating Ring for Valve system with BP58, inch	101.36
4	LR0082	Locating Ring for Valve system with BP58, metric	109.77
5	LR0086	Locating Ring for Sprue system with BP58, inch	101.36
6	LR0087	Locating Ring for Sprue system with BP58, metric	109.77

528

Relevant Catalog Pages

526

Catalog Page	Title	Revision Date	CAD Drawings
View	10.01.11 Manifold center heater	98-Oct-22	Download
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download
View	M8.02.02 2-Inline Sub Manifold	Jun	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41 AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41 AM	Download

FIG. 27

540
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Molding Elevation
If you wish to include a Molding Elevation, please enter it below and choose the Unit of Measure.
Click HERE for more information.
Previous Step
There is no Molding Elevation range available for this application. Click Next to continue or try another application.
Next
X
L
D
Gate Seal
Water Cooled Gate Insert
Locating Ring
Nozzle
Valve Actuator
Manifold Plates
Manifold
Inlet Component
544
Relevant Catalog Pages
Catalog Page
Title
Revision Date
CAD Drawings
542
View M9.01.08 Locating Ring for Valve system with BP58, inch
Jun 6 2000 12:41 AM
Download
View 10.01.11 Manifold center heater
98-Oct-22
Download
View 12.01.12 Hydraulic/Pneumatic Cylinder Assembly
98-Oct-22
Download
View M8.02.02 2-Inline Sub Manifold
Jun
Download
View M8.01.05 Mim Dura Hecto Valve nozzle L=120
Jun 6 2000 12:41 AM
Download
View M8.01.05 MDH C VALVE TS0664 + TSL229
Jun 6 2000 12:41 AM
Download
View M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve
Jun 6 2000 12:41 AM
Download

FIG. 28

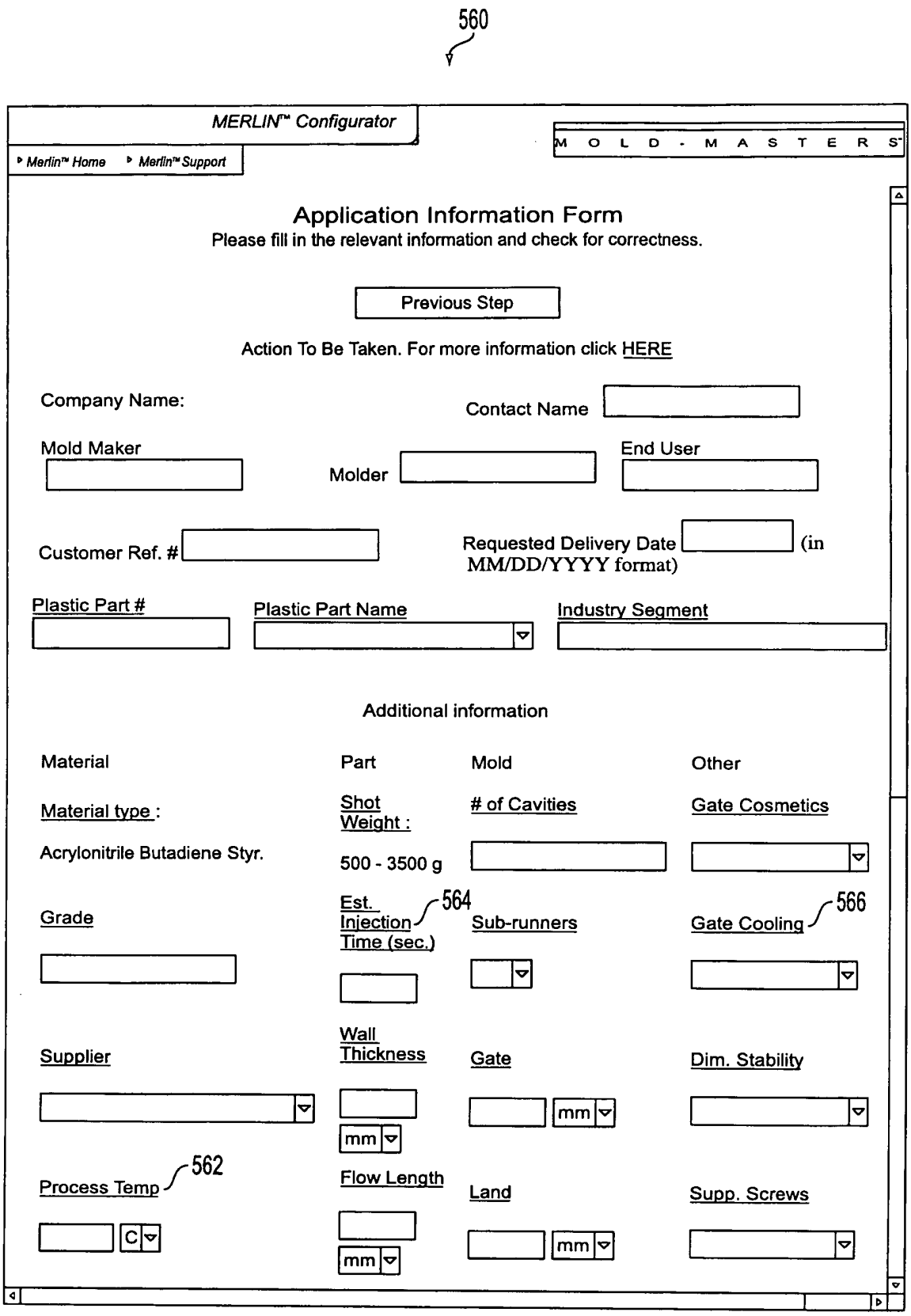

560
MERLIN™ Configurator
MOLD-MASTERS
Merlin™ Home
Merlin™ Support
Application Information Form
Please fill in the relevant information and check for correctness.
Previous Step
Action To Be Taken. For more information click HERE
Company Name:
Contact Name
Mold Maker
Molder
End User
Customer Ref. #
Requested Delivery Date (in MM/DD/YYYY format)
Plastic Part #
Plastic Part Name
Industry Segment
Additional information
Material
Part
Mold
Other
Material type :
Acrylonitrile Butadiene Styr.
Shot Weight :
500 - 3500 g
# of Cavities
Gate Cosmetics
Grade
Est. Injection Time (sec.)
564
Sub-runners
Gate Cooling
566
Supplier
Wall Thickness
Gate
Dim. Stability
mm
Process Temp
562
C
Flow Length
Land
Supp. Screws

FIG. 29

580

MERLIN™ Configurator

M O L D - M A S T E R S™

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Summary Information Form

Please fill in the relevant information and check for correctness.

Previous Step | View Printable Version

Action To Be Taken. For more information click HERE

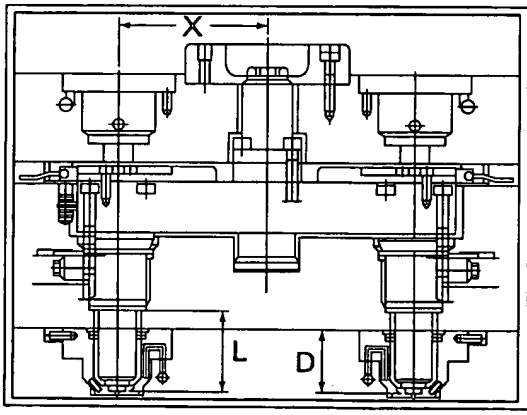
Step 1	Step 2	Step 3	Step 4
Save (582)	Quote (584)	Review (586)	Order (588)
Lead Time: No Lead Time Available.	Quote #: 0040003107	Not Reviewed.	Order #:
Generate Drawings (590)	Price: $6,681.00 USD		PO # N/A

Company Name: Contact Name:

Mold Maker: Molder: End User:

Customer Ref. # : Requested Delivery Date:

Plastic Part # : Plastic Part Name: Industry Segment:



Required Parts List

Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH21200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

Additional Information

Material	Part	Mold	Other
Material type : Acrylonitrile Butadiene Styr.	Shot Weight : 500 - 3500g	# of Cavities :	Gate Cosmetics :
Grade:	Est. Injection Time (sec.):	Sub-runners:	Gate Cooling:
Supplier:	Wall Thickness:	Gate:	Dim. Stability:

FIG. 30

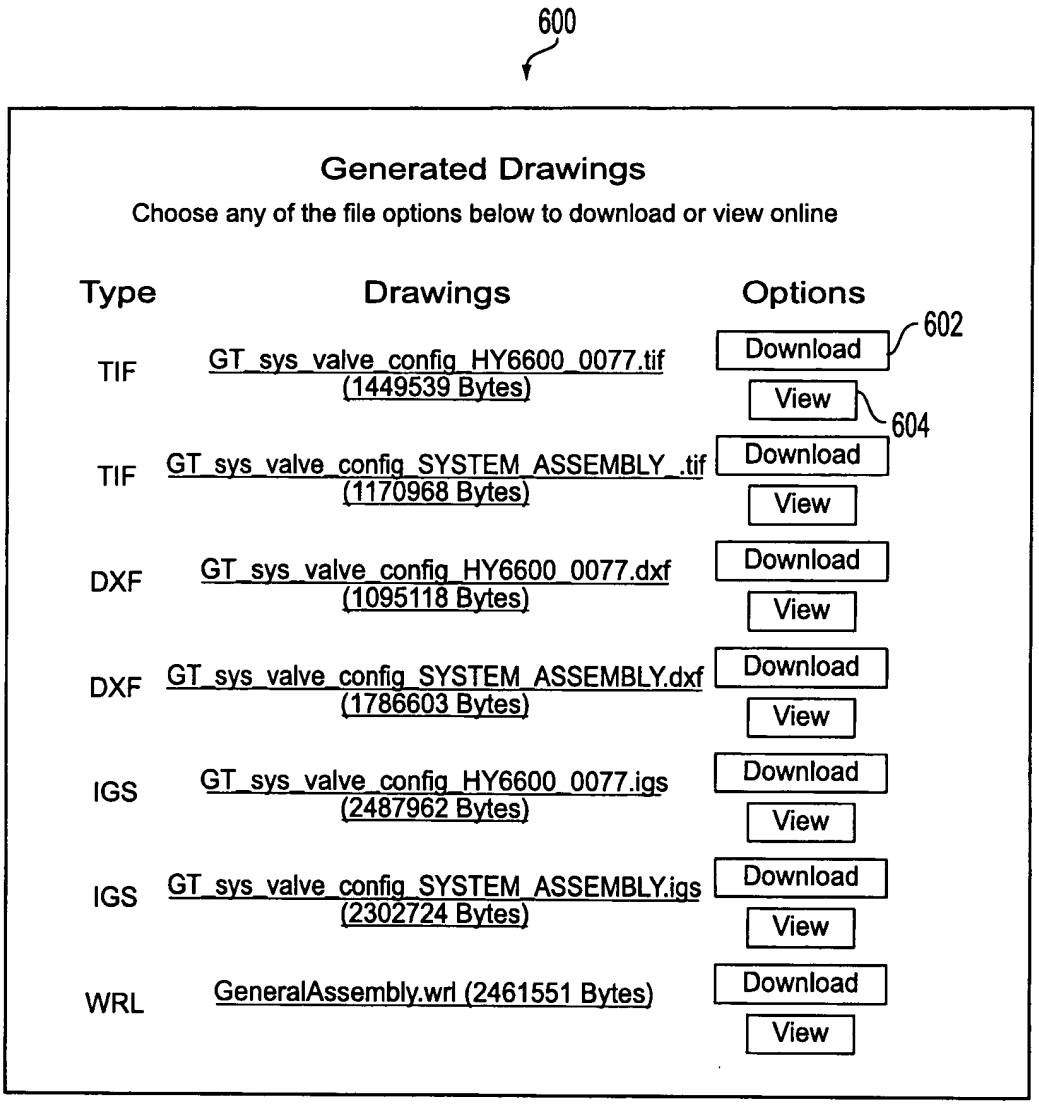

600
Generated Drawings
Choose any of the file options below to download or view online
Type
Drawings
Options
602
604
TIF
GT_sys_valve_config_HY6600_0077.tif (1449539 Bytes)
Download
View
TIF
GT_sys_valve_config_SYSTEM_ASSEMBLY_.tif (1170968 Bytes)
Download
View
DXF
GT_sys_valve_config_HY6600_0077.dxf (1095118 Bytes)
Download
View
DXF
GT_sys_valve_config_SYSTEM_ASSEMBLY.dxf (1786603 Bytes)
Download
View
IGS
GT_sys_valve_config_HY6600_0077.igs (2487962 Bytes)
Download
View
IGS
GT_sys_valve_config_SYSTEM_ASSEMBLY.igs (2302724 Bytes)
Download
View
WRL
GeneralAssembly.wrl (2461551 Bytes)
Download
View

FIG. 31

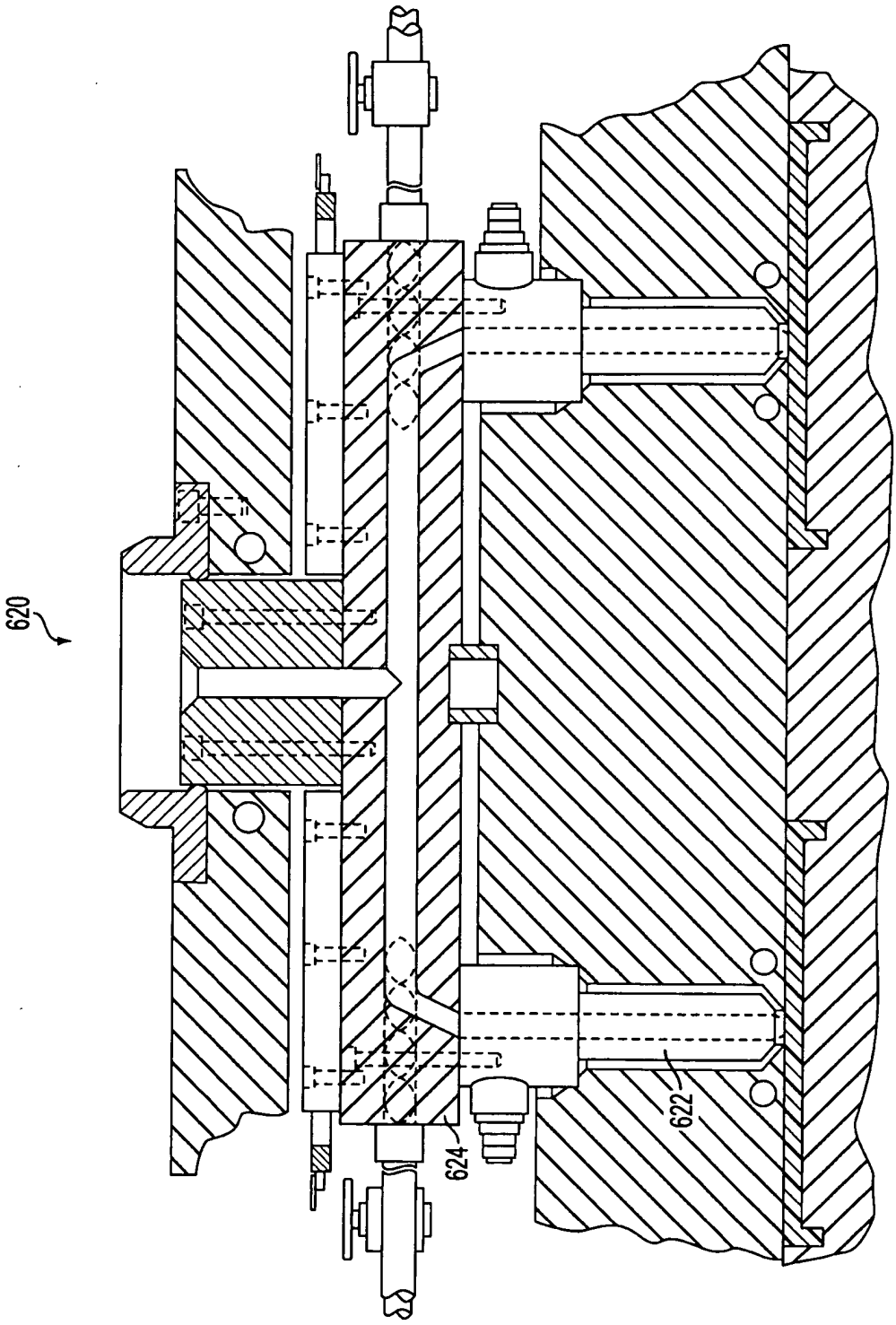


FIG. 32

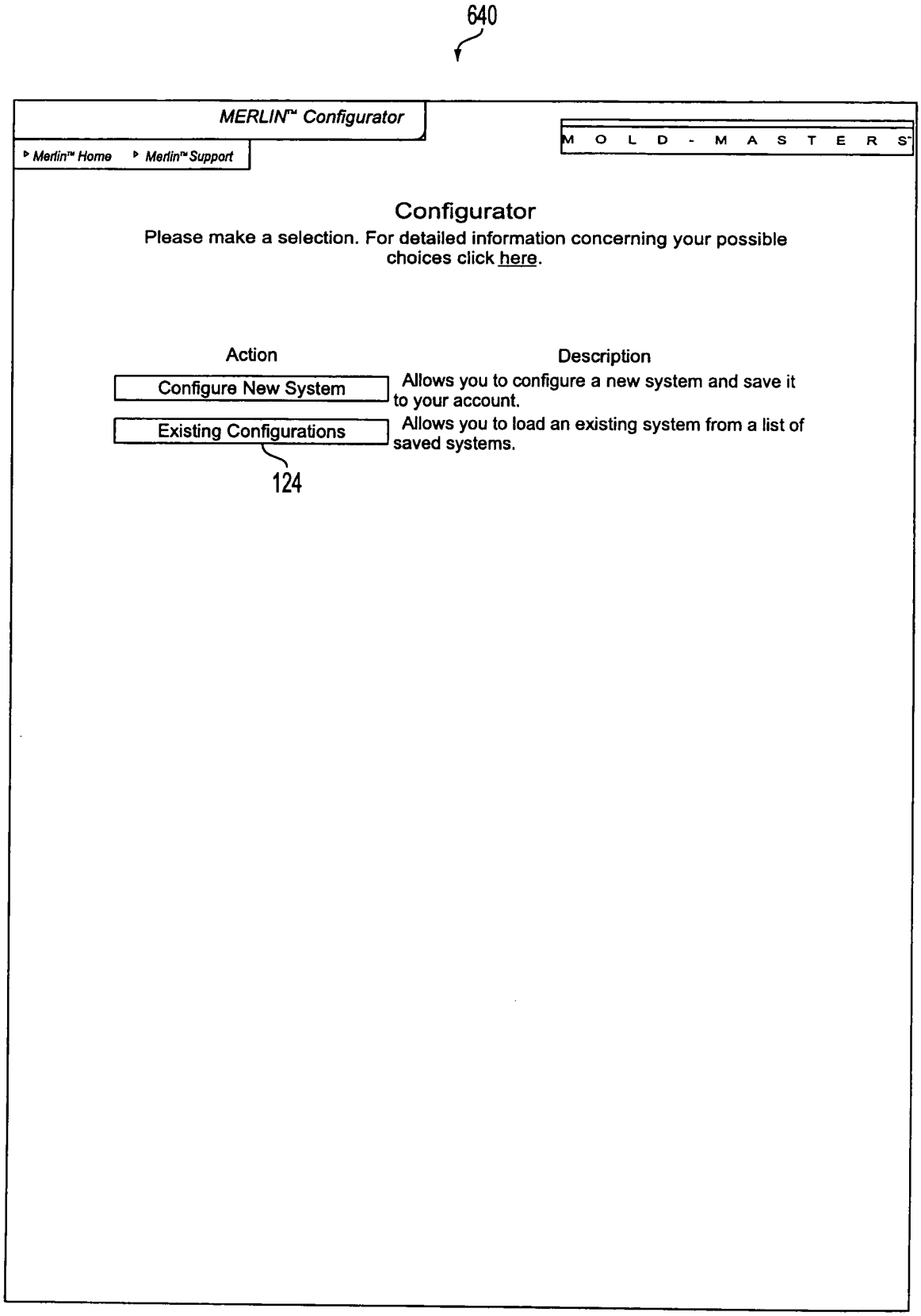

640
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S™
Configurator
Please make a selection. For detailed information concerning your possible choices click here.
Action
Description
Configure New System
Allows you to configure a new system and save it to your account.
Existing Configurations
Allows you to load an existing system from a list of saved systems.
124

FIG. 33

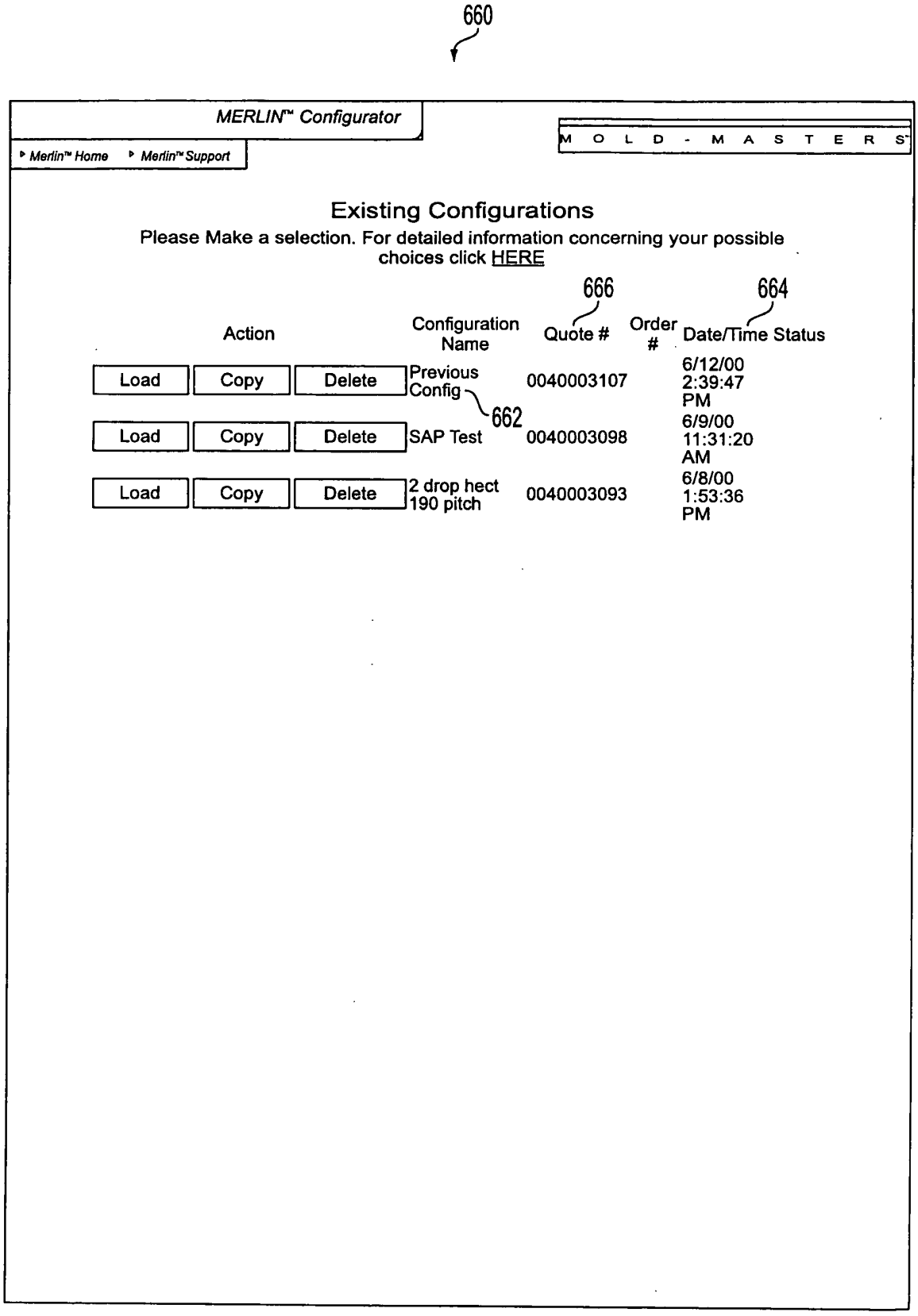

660
MERLIN™ Configurator
Merlin™ Home
Merlin™ Support
M O L D - M A S T E R S
Existing Configurations
Please Make a selection. For detailed information concerning your possible choices click HERE
666
664
Action
Configuration Name
Quote #
Order #
Date/Time Status
Load
Copy
Delete
Previous Config
0040003107
6/12/00 2:39:47 PM
662
Load
Copy
Delete
SAP Test
0040003098
6/9/00 11:31:20 AM
Load
Copy
Delete
2 drop hect 190 pitch
0040003093
6/8/00 1:53:36 PM

FIG. 34

680

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M O L D - M A S T E R S

Summary Information Form

Please fill in the relevant information and check for correctness.

Previous Step | View Printable Version

Action To Be Taken. For more information click HERE

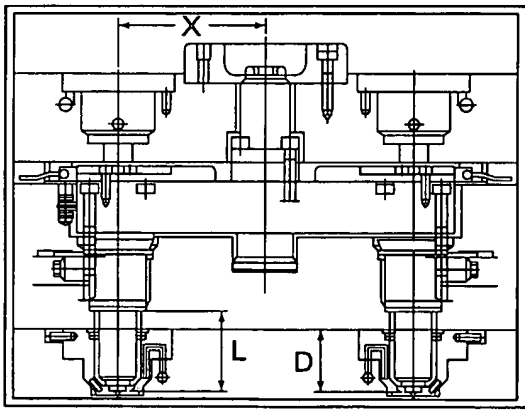
Step 1 (682)	Step 2 (684)	Step 3 (686)	Step 4 (688)
Save	Quote	Review	Order
Lead Time: No Lead Time Available.	Quote #: 0040003107	Not Reviewed.	Order #:
Generate Drawings	Price: $6,681.00 USD		PO # N/A

Company Name: (670) Contact Name:

Mold Maker: Molder: End User:

Customer Ref. # : Requested Delivery Date:

Plastic Part # : Plastic Part Name: Industry Segment:



Required Parts List

Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH21200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

Additional Information

Material	Part	Mold	Other
Material type : Acrylonitrile Butadiene Styr.	Shot Weight : 500 - 3500g	# of Cavities :	Gate Cosmetics :
Grade:	Est. Injection Time (sec.):	Sub-runners:	Gate Cooling:
Supplier:	Wall Thickness:	Gate:	Dim. Stability:

FIG. 35

FIG. 36

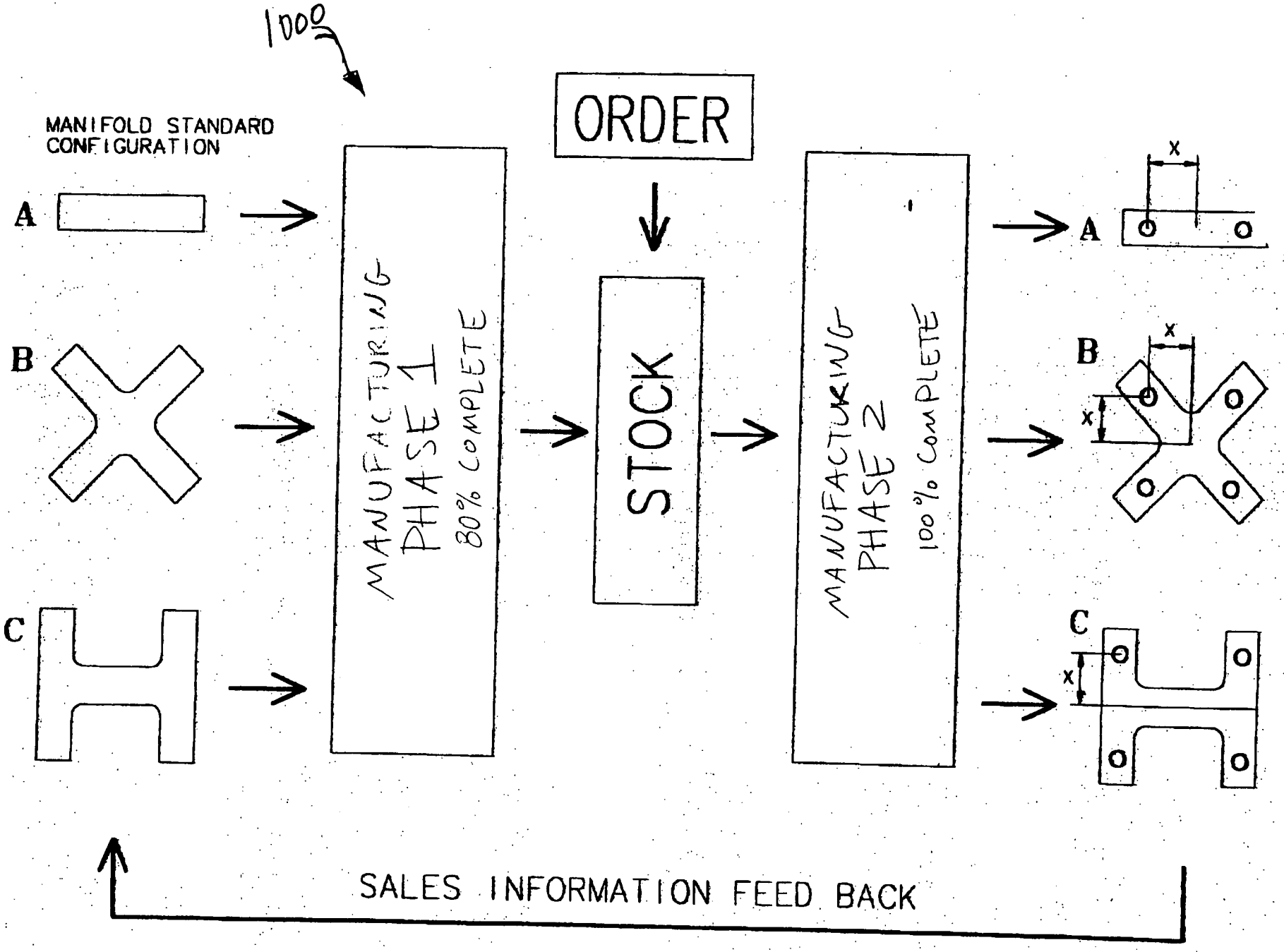

1000
MANIFOLD STANDARD CONFIGURATION
A
B
C
ORDER
MANUFACTURING PHASE 1
80% COMPLETE
STOCK
MANUFACTURING PHASE 2
100% COMPLETE
A
B
C
X
X
X
SALES INFORMATION FEED BACK

FIG. 37

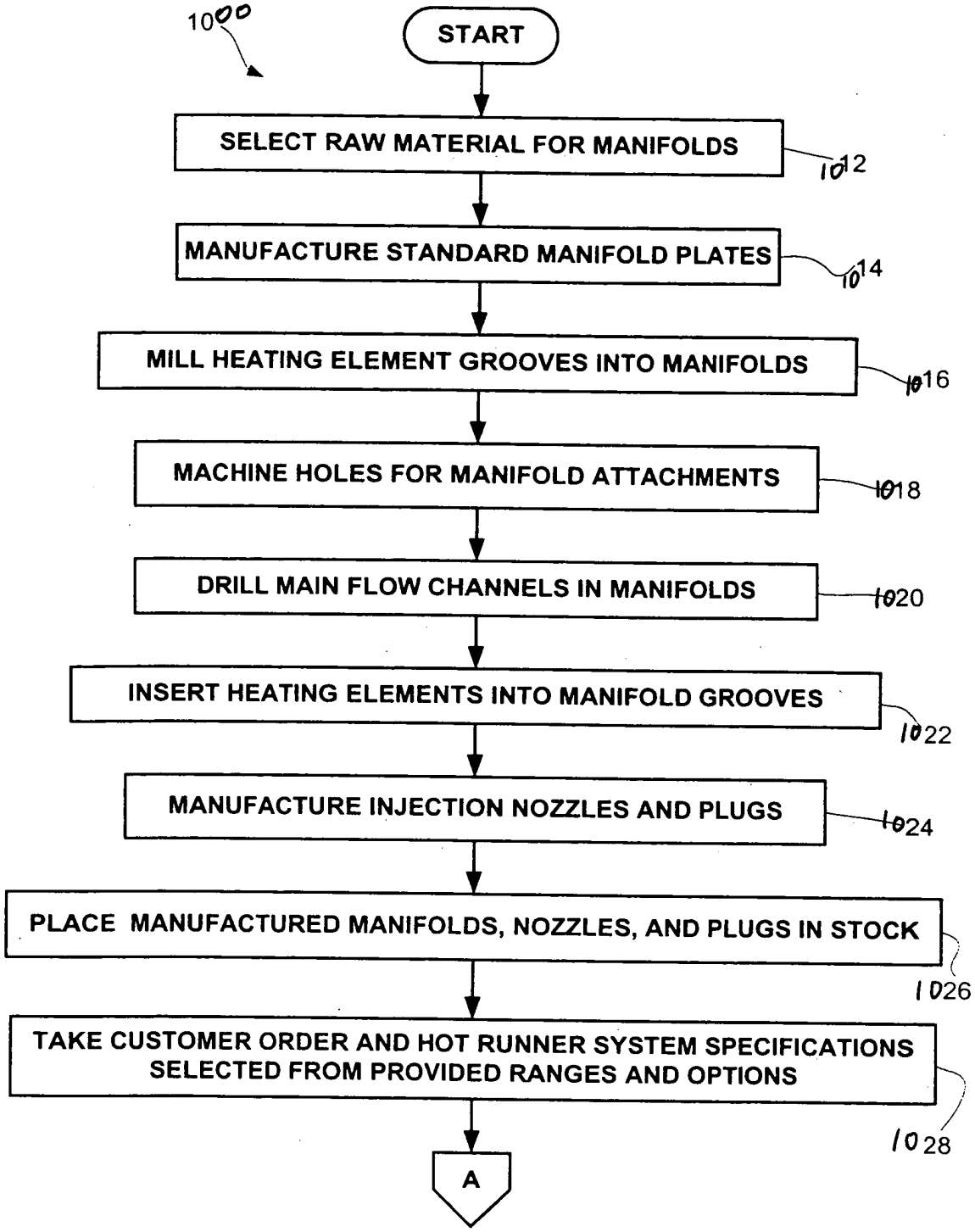
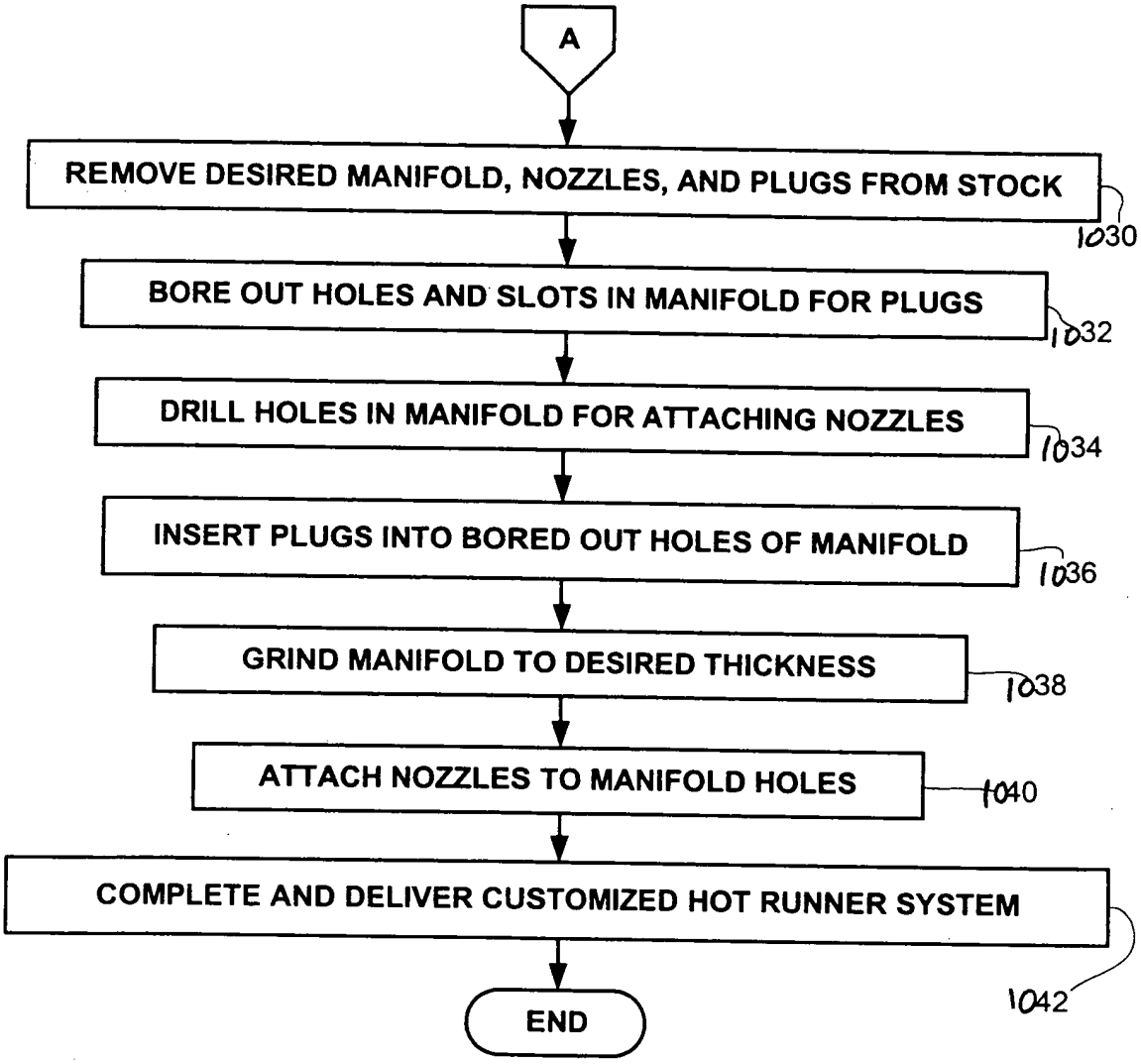

1000
START
SELECT RAW MATERIAL FOR MANIFOLDS
1012
MANUFACTURE STANDARD MANIFOLD PLATES
1014
MILL HEATING ELEMENT GROOVES INTO MANIFOLDS
1016
MACHINE HOLES FOR MANIFOLD ATTACHMENTS
1018
DRILL MAIN FLOW CHANNELS IN MANIFOLDS
1020
INSERT HEATING ELEMENTS INTO MANIFOLD GROOVES
1022
MANUFACTURE INJECTION NOZZLES AND PLUGS
1024
PLACE MANUFACTURED MANIFOLDS, NOZZLES, AND PLUGS IN STOCK
1026
TAKE CUSTOMER ORDER AND HOT RUNNER SYSTEM SPECIFICATIONS SELECTED FROM PROVIDED RANGES AND OPTIONS
1028
A

FIG. 37 Cont.


A
REMOVE DESIRED MANIFOLD, NOZZLES, AND PLUGS FROM STOCK
1030
BORE OUT HOLES AND SLOTS IN MANIFOLD FOR PLUGS
1032
DRILL HOLES IN MANIFOLD FOR ATTACHING NOZZLES
1034
INSERT PLUGS INTO BORED OUT HOLES OF MANIFOLD
1036
GRIND MANIFOLD TO DESIRED THICKNESS
1038
ATTACH NOZZLES TO MANIFOLD HOLES
1040
COMPLETE AND DELIVER CUSTOMIZED HOT RUNNER SYSTEM
1042
END

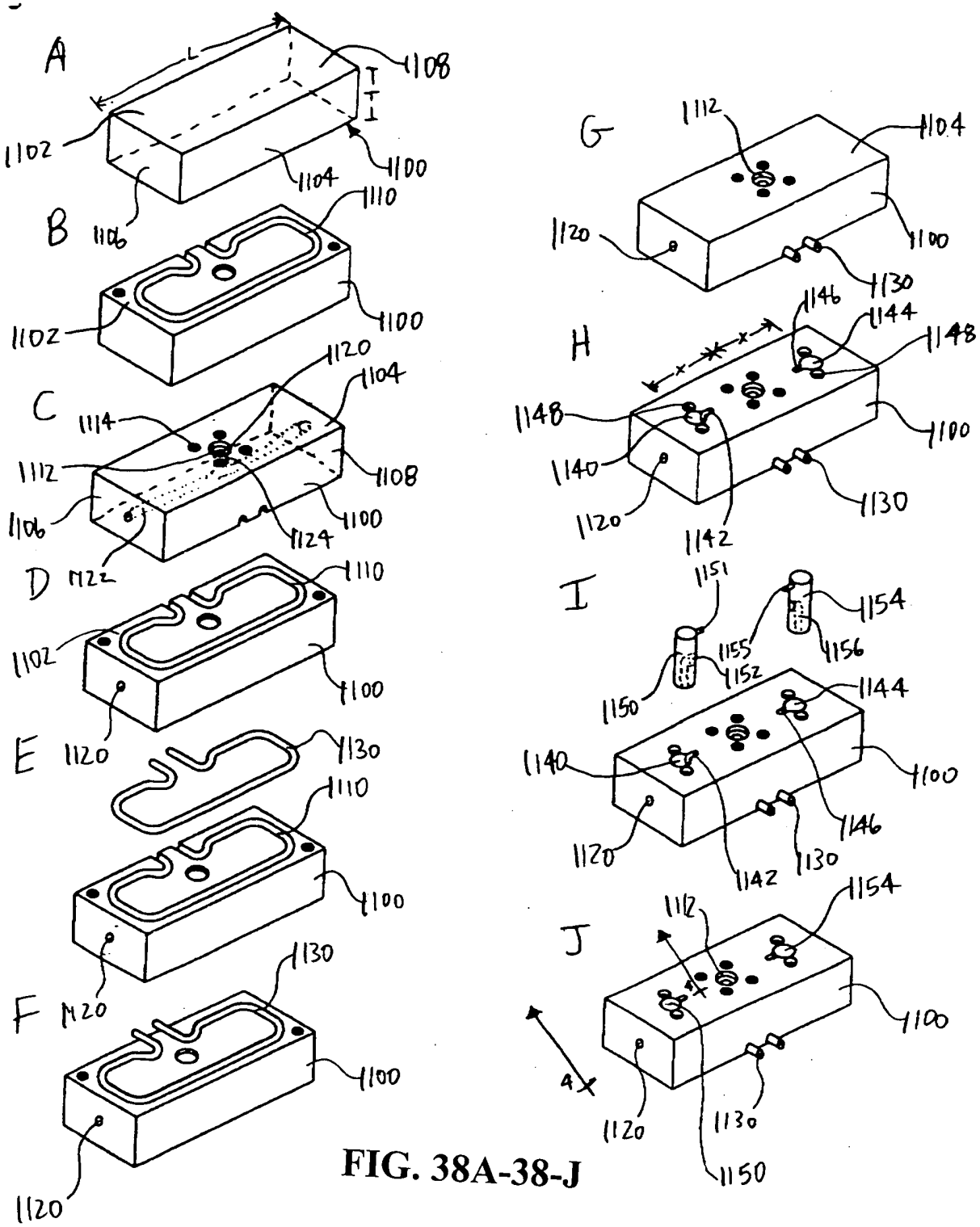

A
L
T
T
1108
1102
1104
1100
B
1110
1106
1102
1100
C
1120
1104
1114
1112
1108
1106
1124
1100
D
1122
1110
1102
1100
E
1120
1130
1110
1100
F
1120
1130
1100
1120
G
1112
1104
1120
1100
1130
H
1146
1144
1148
1148
1100
1140
1130
1120
1142
I
1151
1154
1155
1156
1152
1150
1144
1140
1100
1146
1120
1142
1130
J
1154
1112
1100
4
1120
1130
1150

FIG. 38A-38-J

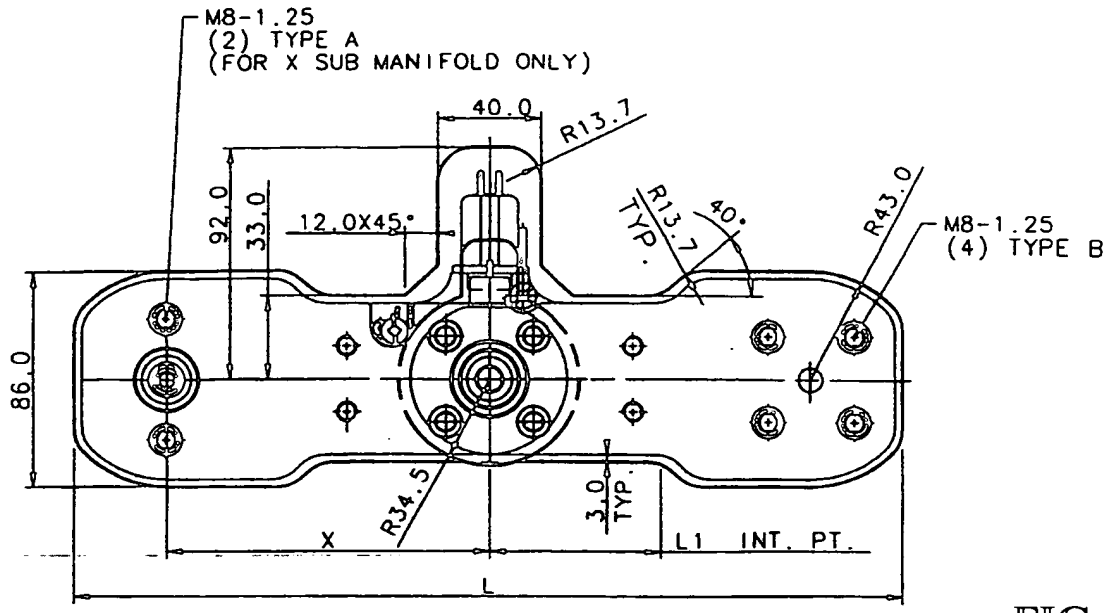
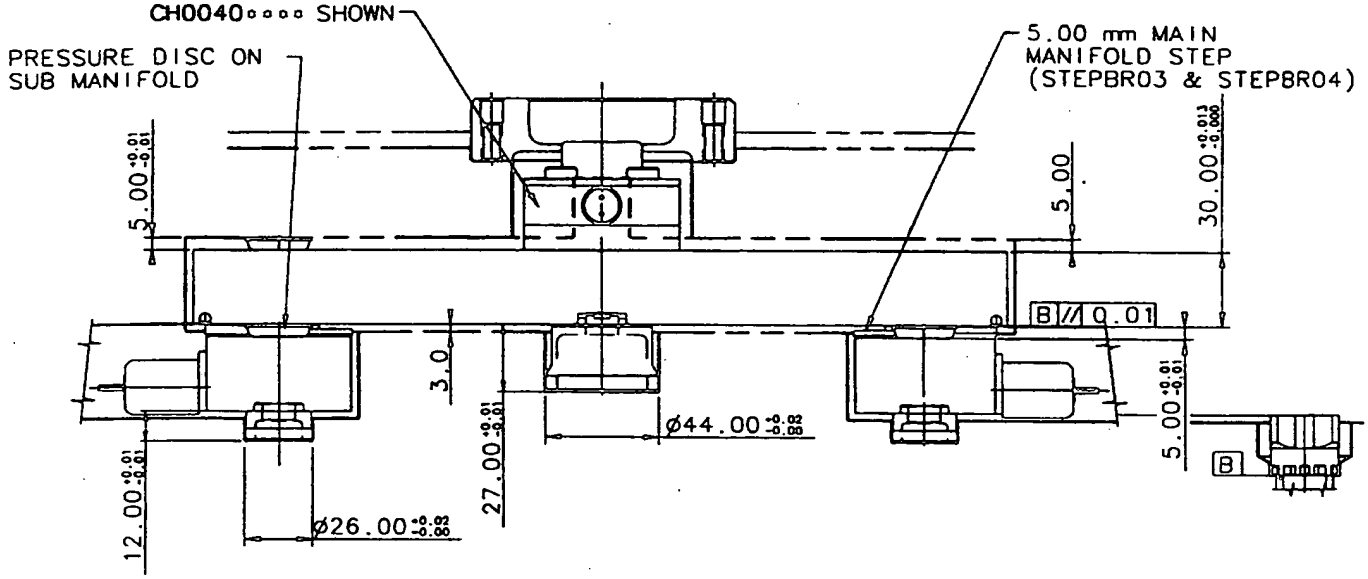


FIG. 38K



MN521125BL1 SHOWN
SCALE -1:3

SPEED OPTION	MAIN MANIFOLD OPTIONS				
	MANIFOLD BLANK#	X (PITCH RANGE)	L	L1	POWER (WATTS○220V)
✓	MN521125BL1	100.00-125.00	322.0	65.7	1650
✓	MN521150BL1	125.01-150.00	372.0	90.7	2450
✓	MN521175BL1	150.01-175.00	422.0	115.7	2750
✓	MN521200BL1	175.01-200.00	472.5	140.7	2500
✓	MN521225BL1	200.01-225.00	522.5	165.7	2600
✓	MN521250BL1	225.01-250.00	572.5	190.7	2800

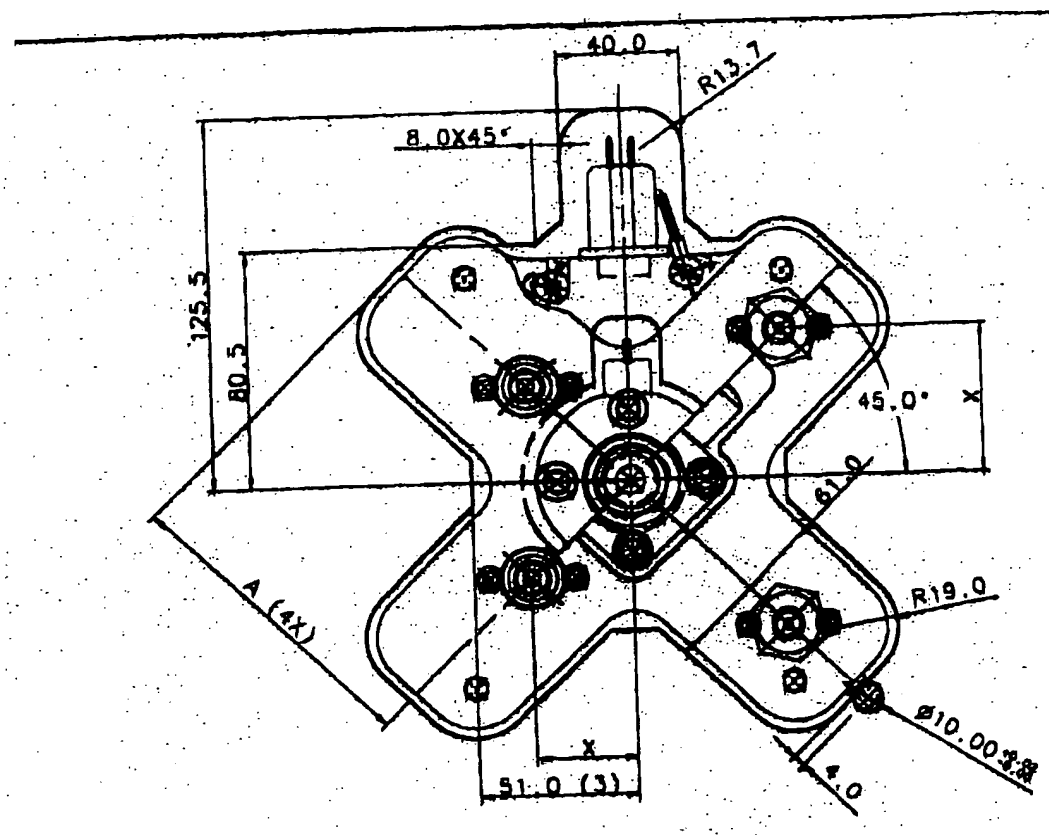
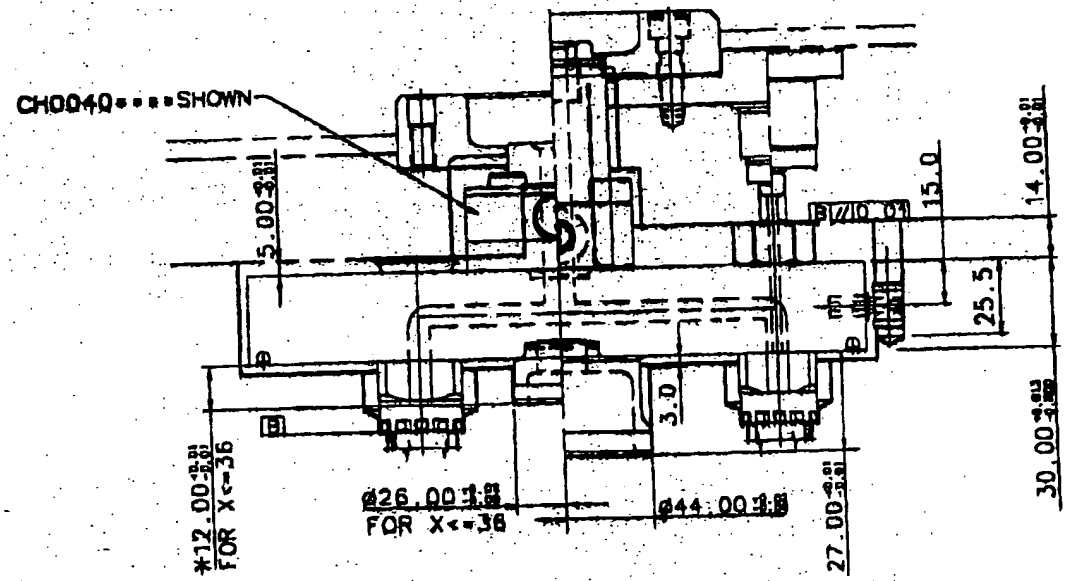


FIG. 38L



MNMDP0X050BL1A SHOWN
SCALE 1:2.5

MIM SPEED OPTION
✓
✓

MANIFOLD OPTIONS				
MANIFOLD BLANK#	X (PITCH RANGE)	GATE TYPE	A	POWER (WATTS 220V)
MNMDP0X050BL1A	32.50-50.00	S	104.0	1550 W
MNMDP0X050BL1A	50.00	V	104.0	1550 W

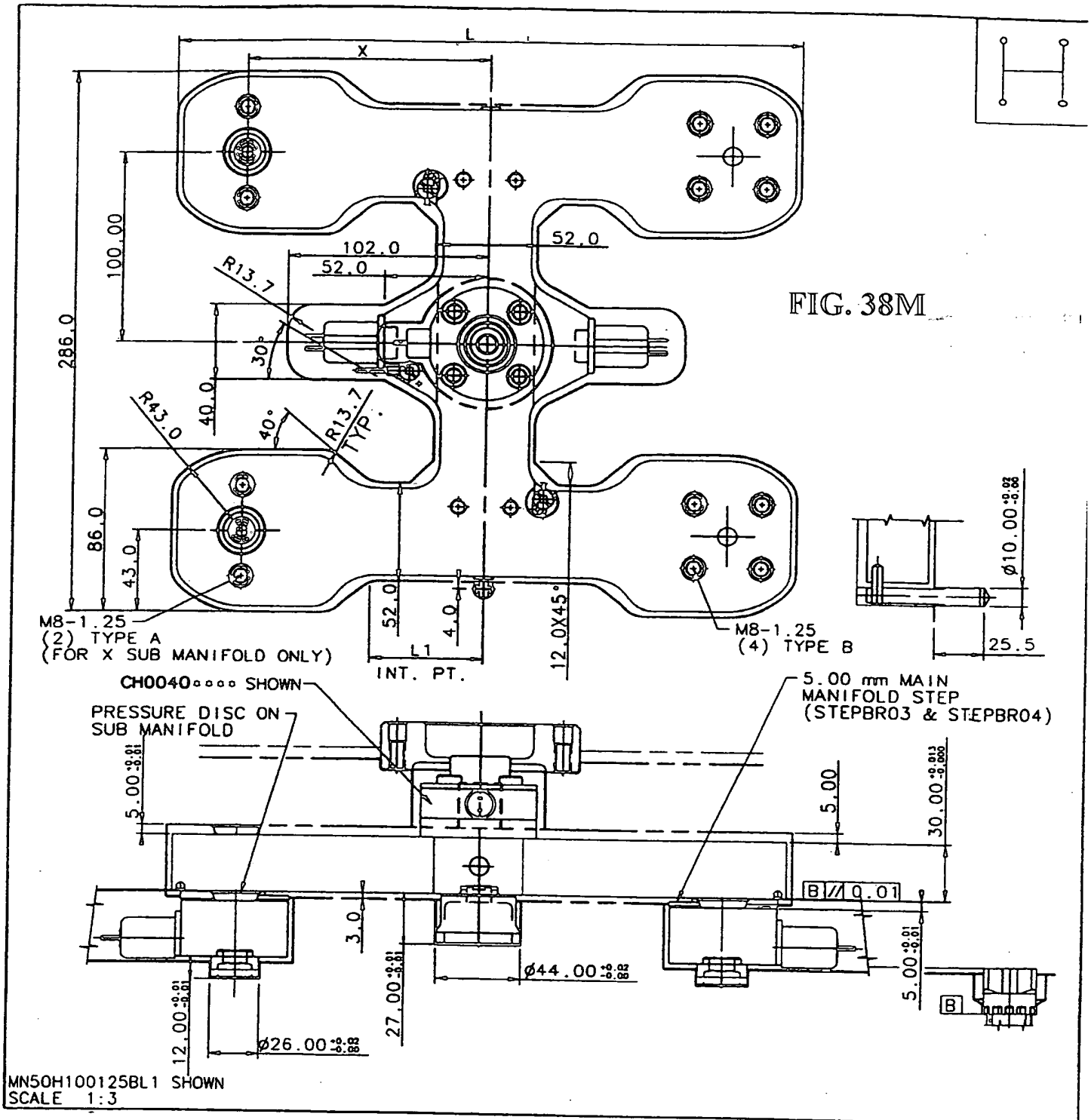


FIG. 38M

MM SPEED OPTION
✓
✓
✓
✓

MAIN MANIFOLD OPTIONS				
MANIFOLD BLANK#	X (PITCH RANGE)	L	L1	POWER (WATTS○220V)
MN50H100125BL1	100.00-125.00	322.0	57.3	2200
MN50H100150BL1	125.01-150.00	372.0	82.3	2400
MN50H100175BL1	150.01-175.00	422.0	107.3	2600
MN50H100200BL1	175.01-200.00	472.5	132.3	2800

FIG. 39

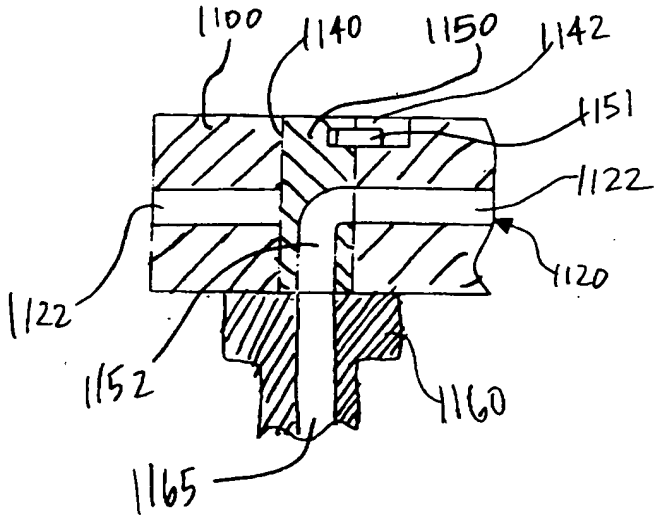


FIG. 40

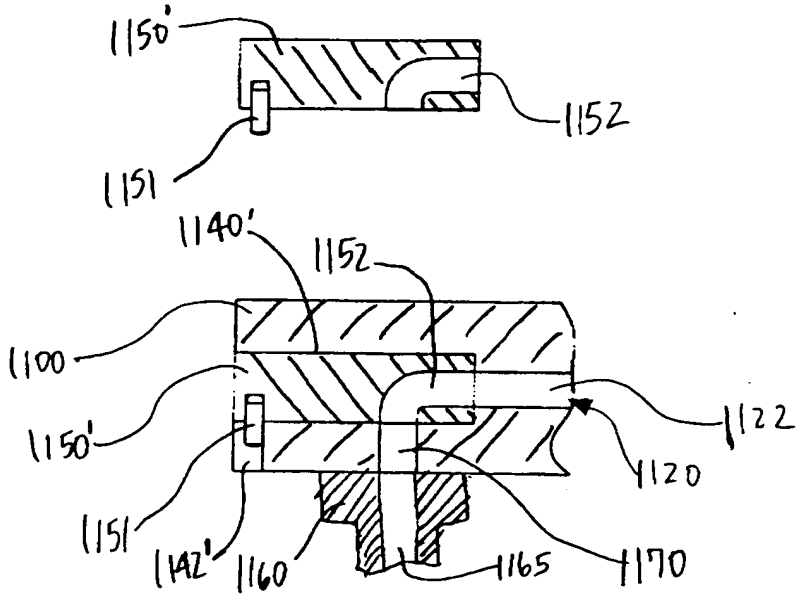


FIG. 41